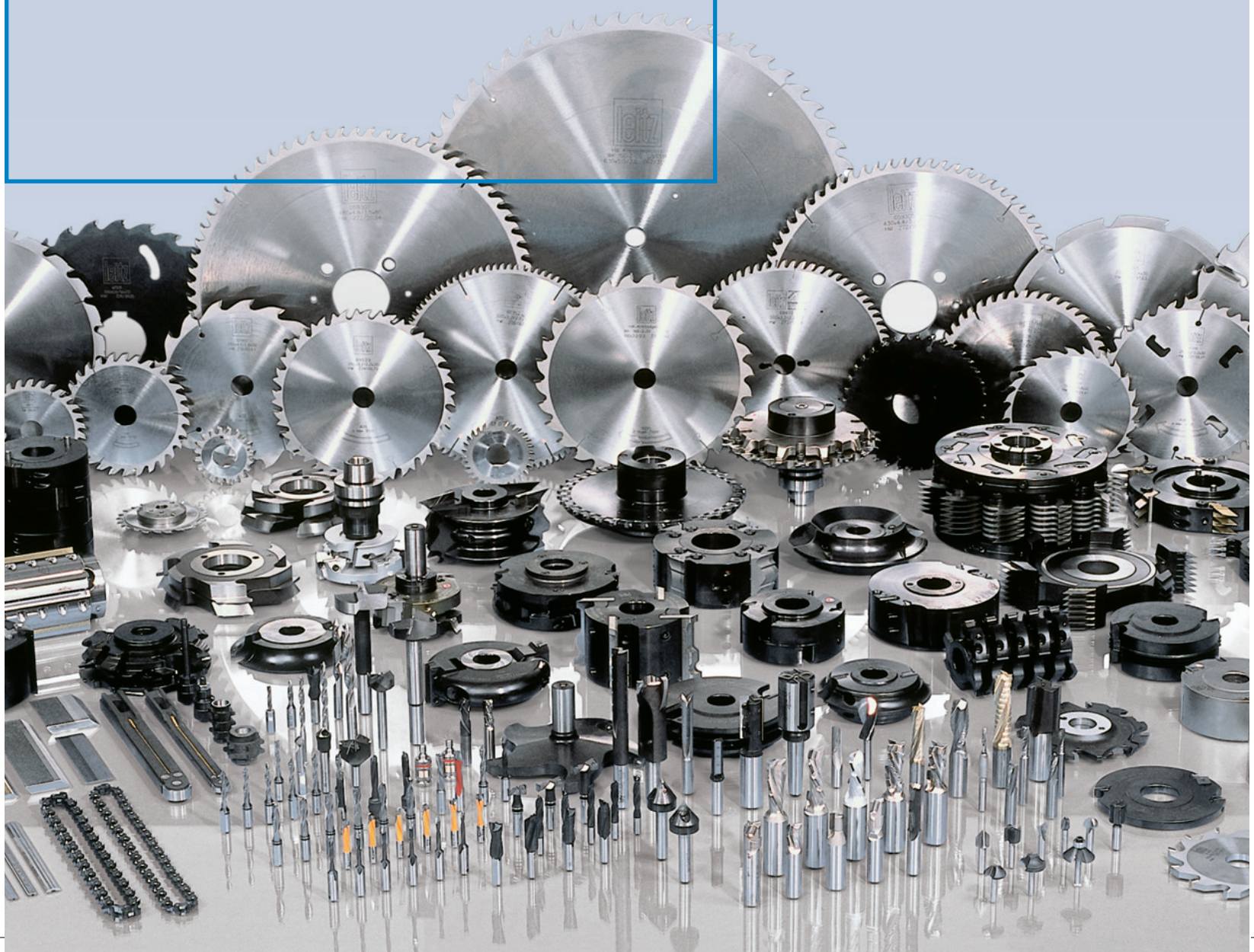




Compact Tooling Program Catalog

Tools and tooling systems
for wood and advanced materials





Tooling Your Business For Success

As your business has realigned to meet the challenges of manufacturing in the past several years, Leitz Tooling has also worked hard to be effective, efficient and accomplished. We are committed to helping you exceed the expectations and requirements of manufacturing in this millennium.

That means new techniques, new technologies and continuous innovation. As manufacturing consultants and partners, we look forward to working with you to understand the needs of your business. The more we know, the more we can do.

Leitz has built a reputation as a leading tooling manufacturer and service provider. We understand that we have to earn that leadership with every tool and every contact. We continuously strive to improve our technical capabilities, expand our industry knowledge and provide more effective production advice. At Letiz, our focus is to ensure that your business is tooled for success.

Our Compact Tooling Program catalog provides you with a quick and easy reference for our most popular tooling choices. You can also find more in-depth information at www.leitztooling.com or contact one of our Tooling Consultants at 800 253 6070.



Contents

1. Sawing	1.1 Professional Series Saw Blades	3
	1.2 Sliding Table, Vertical Saw Blades	4 - 6
	1.3 Rip Saw Blades	7
	1.4 Panel Saw Blades	8
	1.5 Industrial Mitre, Optimizing, Countertop Saw Blades.....	9
	1.6 Non-Ferrous Saw Blades	10
	1.7 Specialty Saw Blades	11 - 12
2. Routing	2.1 Solid Carbide Router Bits	13 - 15
	2.2 Diamond Router Bits	16 - 17
	2.3 Grooving Saw Blades	18
	2.4 V-Grooving, Finish Cutters	19
	2.5 Jointing, Rebating	20
	2.6 MDF Doors	21 - 22
	2.7 Fly Cutters	23
	2.8 Beveling Tools	24
	2.9 Chucks, Collets, Heat Shrink Units	25 - 26
	2.10 CNC Saw Flanges	27
3. Drilling	3.1 Dowel, V-Point, Hinge Drill Bits	28 - 29
4. Planing	4.1 HeliPlan Cutterheads	30
	4.2 VariPlan Plus Cutterheads	31
	4.3 Knives	32
5. Edgebanding	5.1 WhisperCut Pre-Mill Cutterheads	33 - 34
	5.2 Snip Saw Blades	35 - 36
6. Profiling	6.1 Corrugated Cutterheads, Knives	37
	6.2 VariForm Cutterheads	38
	6.3 Rebating Cutterheads	39
	6.4 Beveling Cutterheads	40
	6.5 ProfileCut Cutterheads	41 - 43
7. Standard Knives	7.1 Standard Knives	44

1. Sawing

1.1 Professional Series Saw Blades

**Professional Series Saw Blades****Application:**

Professional quality saw blades, in various styles to cut a variety of common materials.

Machine:

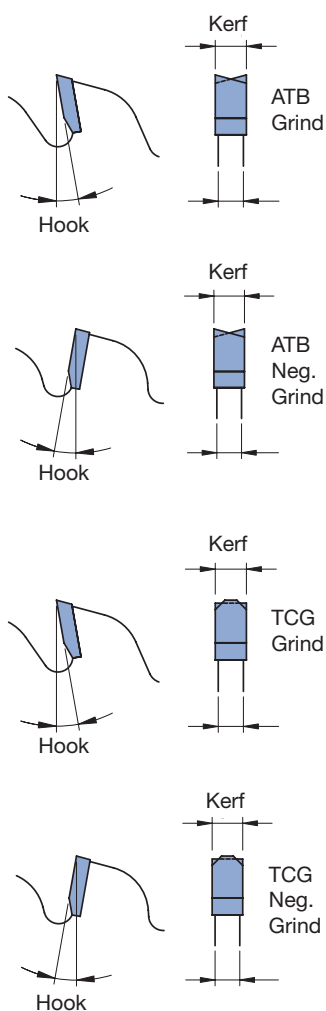
Table and chop saws.

Workpiece Material:

Various materials per Technical Selection Guide below.

Technical Selection Guide

NW	Natural Woods & Plywood
PS	Panel Sizing (Particle/MDF)
HP	Hard Plastics
SP	Soft Plastics
SS	Solid Surface
NF	Non-Ferrous Metal

Product Specifications

D	Kerf	Bore	Teeth	Grind	Hook	Application	ID#
10"	.125"	5/8"	24	ATB	15°	NW	737316207
10"	.125"	5/8"	50	ATB/R	15°	NW, PS	737316173
12"	.142"	1"	28	ATB	15°	NW, SP	737316208
12"	.142"	1"	48	ATB	15°	NW	737316209
10"	.125"	5/8"	40	ATB	12°	NW, PS	737316170
10"	.125"	5/8"	60	ATB	12°	NW, PS	737316171
10"	.125"	5/8"	80	ATB	8°	NW, PS	737316210
12"	.125"	1"	80	ATB	-6°	NW, PS	737316176
12"	.142"	1"	60	ATB	10°	NW, PS	737316211
12"	.142"	1"	96	ATB	5°	NW, PS	737316723
14"	.158"	1"	72	ATB	12°	NW, PS	737316213
14"	.173"	1"	84	ATB	12°	NW, PS	737316214
10"	.125"	5/8"	80	ATB	-6°	NW, PS	737316215
10"	.125"	5/8"	80	H/ATB	-6°	NW, PS	737316216
12"	.098"	1"	96	ATB	-6°	NW	737316177
10"	.125"	5/8"	60	TCG	12°	PS	737316217
10"	.125"	5/8"	80	TCG	10°	PS	737316172
12"	.142"	1"	60	TCG	10°	PS	737316175
12"	.142"	1"	72	TCG	10°	PS	737316218
12"	.142"	1"	96	TCG	10°	PS	737316219
14"	.173"	1"	84	TCG	10°	PS	737316220
8"	.110"	5/8"	48	TCG	-6°	PS, HP, SS, NF	737316221
10"	.117"	5/8"	60	TCG	-6°	PS, NF	737316222
10"	.117"	5/8"	80	TCG	-6°	PS, NF, HP, SS	737316224
12"	.125"	5/8"	60	TCG	-6°	PS	737316225
12"	.142"	5/8"	96	TCG	-5°	PS, NF, HP, SS	737316174

1. Sawing

1.2 Sliding Table, Vertical Saw Blades



Sliding Table Saw Blades

Application:

Sizing of panel products.

Machine:

Sliding table, vertical and countertop saws.

Workpiece Material:

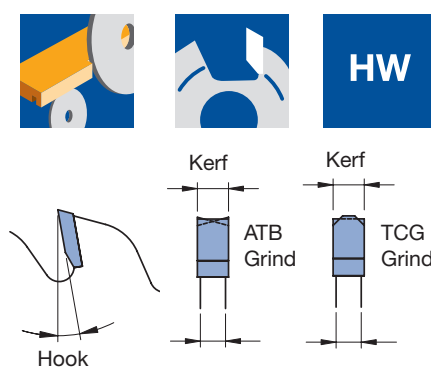
Panel products and plywood, raw or plastic, HPL, veneer laminated.

Technical Information:

Cutting with or without scoring, adjustable width split score blades for clean cuts on material top and bottom.

Product Specifications

Sliding Table Saw Blades



D mm	Kerf mm	Bore mm	Teeth	Grind	Hook	Driver Element	Driver Dim*	ID#
300	3.2	30	72	ATB	10°	Pins	CPH	58384
350	3.2	30	84	ATB	10°	Pins	CPH	58386
400	3.2	30	96	ATB	10°	Pins	CPH	58387
300	3.2	30	72	TCG	10°	Pins	2/10/60	156002092
350	3.2	30	84	TCG	10°	Pins	2/10/60	130008064

*CPH: Combined Pin Holes (2/7/42) + (2/9/46.35) + (2/10/60)



Sizing without scoring *Excellent*

Application:

For sizing and cross cutting without scoring.

Machine:

Table and sizing saws, vertical panel sizing saws without scoring unit.

Workpiece Material:

Chipboard and fiber materials plastic and paper coated, veneered.

Technical Information:

Excellent design with plastic filled laser ornaments for vibration amping and reduction of noise level.

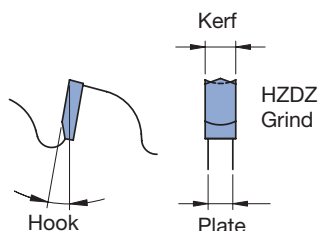


Product Specifications

Circular Saw Blade Excellent

WK 874 2

D mm	Kerf mm	Plate mm	Bore mm	Teeth	Grind	Hook	Driver Element	ID#
250	3.2	2.2	30	54	HZ/DZ	10°	CPH	161300
303	3.2	2.2	30	68	HZ/DZ	10°	CPH	161301
350	3.5	2.5	30	80	HZ/DZ	10°	CPH	161302



1. Sawing

1.2 Sliding Table, Vertical Saw Blades

**Sizing without scoring *Premium*****Application:**

For sizing and cross cutting without scoring.

Machine:

Table and sizing saws, vertical panel sizing saws without scoring unit.

Workpiece Material:

Chipboard and fiber materials plastic and paper coated, veneered.

Technical Information:

Premium design with vibration damping laser ornaments.

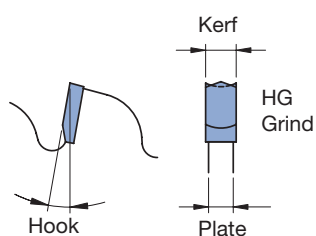
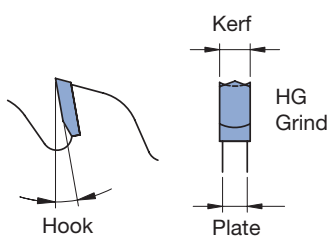


HW

**Product Specifications****Circular Saw Blade Premium, positive cutting angle**

WK 274 2

D mm	Kerf mm	Plate mm	Bore mm	Teeth	Grind	Hook	Driver Element	ID#
220	3.2	2.2	30	42	HG	10°	CPH	163050
250	3.2	2.2	30	48	HG	10°	CPH	163051
303	3.5	2.5	30	60	HG	10°	CPH	163052
350	3.5	2.5	30	72	HG	10°	CPH	163053

**Machine:**

Vertical panel sizing saws without scoring unit.

Technical Information:

Premium design with vibration damping laser ornaments. Better cutting edge at the exit side of the saw blade by negative cutting angle.

Circular Saw Blade, negative cutting angle

WK 864 2

D mm	Kerf mm	Plate mm	Bore mm	Teeth	Grind	Hook	Driver Element	ID#
220	3.2	2.2	30	42	HG	-5°	CPH	163075
250	3.2	2.2	30	48	HG	-5°	CPH	163076
303	3.2	2.2	30	60	HG	-5°	CPH	163077

1. Sawing

1.2 Sliding Table, Vertical Saw Blades



Scoring saw blades with adjustable cutting width

Application:

For scoring with feed.

Machine:

Table and sizing saws, vertical panel sizing saws with scoring unit.

Workpiece Material:

Chipboard and fiber materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood).

Technical Information:

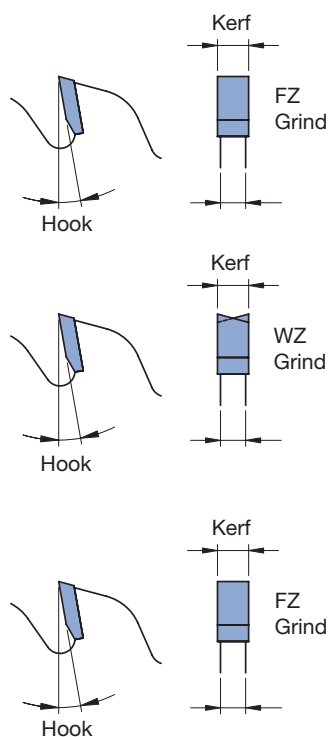
Two part design, adjustable with spacers. Scoring depth 1.5 to 2 mm.



Product Specifications

Scoring Saw Blade, adjustable, HW design

WK 200 2, WK 250 2



Machine	D mm	Kerf mm	Bore mm	Teeth	Grind	Hook	ID#
Robland/Striebig	70	2.8 - 3.8	20	8+8	WZ	10°	165400
Schelling	80	2.8 - 3.8	20	10+10	FZ	10°	165401
Altendorf	100	2.8 - 3.8	20	10+10	FZ	10°	165402
Altendorf	100	2.8 - 3.8	22	10+10	FZ	10°	165403
SCM	120	2.8 - 3.8	20	12+12	FZ	10°	165404
Martin	120	2.8 - 3.6	22	12+12	FZ	10°	165405
T74 Automatic	120	2.8 - 3.8	22	12+12	FZ	10°	165406
Altendorf	125	2.8 - 3.8	20	12+12	FZ	10°	165407
Martin	140	2.8 - 3.8	36	12+12	WZ	10°	165408
SCM	160	2.8 - 3.8	20	16+16	FZ	10°	165409
Altendorf	180	3.0 - 3.8	22	18+18	WZ	10°	165410
SCM	200	4.3 - 5.2	20	30+30	FZ	10°	165411

Scoring Saw Blades for Altendorf Rapido-system, HW design

WK 200 2

Machine	D mm	Kerf mm	Bore mm	Teeth	Grind	Hook	ID#
Altendorf	120	2.8 - 3.8	50	12+12	FZ	10°	165412
Altendorf	180	3.0 - 3.8	50	18+18	FZ	10°	165413

1. Sawing

1.3 Rip Saw Blades

**BlackTron Saw Blades****Application:**

Cutting along grain in natural woods for glue-line finish.

Machine:

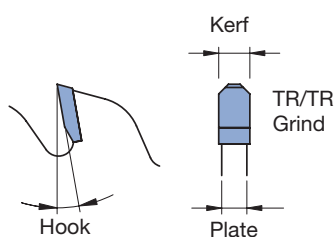
Straight line and gang rip saws.

Workpiece Material:

Softwood and hardwood.

Technical Information:

BlackTron coating resists build-up of resin and significantly enhances tool life.

**Product Specifications****Mereen-Johnson - Driver Dimensions 3-1/8": KN = 9.53 mm x 88.91 mm**

D	Kerf mm	Plate mm	Bore	Teeth	Grind	Hook	Driver Element	ID#
12"	3.5	2.4	3-1/8"	36	TR/TR	20°	1 Key	156017410
12"	4	2.8	3-1/8"	36	TR/TR	20°	1 Key	156017409
12"	4	2.8	3-1/8"	48	TR/TR	20°	1 Key	156017411
14"	4	2.8	3-1/8"	36	TR/TR	20°	4 Pins	470043790

**Raimann - Driver Dimensions 20 mm x 90 mm + (2 mm/13 mm/100 mm),
(4 mm/6.6 mm/95 mm) + (6 mm/5.5 mm/91 mm)**

D mm	Kerf mm	Plate mm	Bore mm	Teeth	Grind	Hook	Driver Element	ID#
300	4	2.8	80	36	TR/TR	20°	2 Keys + 10 Pins	156017404
300	4	2.8	80	28	TR/TR	20°	2 Keys + 10 Pins	165313
300	4	2.8	80	48	TR/TR	20°	2 Keys + 10 Pins	165314
300	2.8	2.0	80	36	TR/TR	20°	2 Keys + 10 Pins	156017405
300	2.8	2.0	80	48	TR/TR	20°	2 Keys + 10 Pins	165311

Ironwood

D mm	Kerf mm	Plate mm	Bore	Teeth	Grind	Hook	Driver Element	ID#
300	4	2.8	1"	36	TR/TR	20°	N/A	156017407
300	4	2.8	1"	48	TR/TR	20°	N/A	156017408

SCM - Driver Dimensions 20.6 mm x 83 mm

D mm	Kerf mm	Plate mm	Bore mm	Teeth	Grind	Hook	Driver Element	ID#
300	4	2.8	70	36	TR/TR	20°	2 Keys	156017412

Table Saw

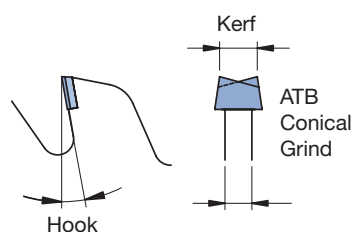
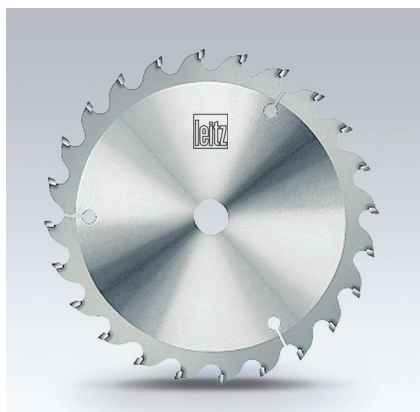
D	Kerf mm	Plate mm	Bore	Teeth	Grind	Hook	Driver Element	ID#
10"	3.4	2.4	5/8"	28	TR/TR	20°	N/A	470043789

Diehl - Driver Dimensions 1 mm/14.28 mm/127 mm

D	Kerf mm	Plate mm	Bore	Teeth	Grind	Hook	Driver Element	ID#
14"	4.8	3.6	2"	42	TR/TR	20°	1 Pin	156017413

1. Sawing

1.4 Panel Saw Blades



Beam Saw Main & Score Blades

Application:

Sizing cuts in panel products.

Machine:

Beam saws and conical score blades.

Workpiece Material:

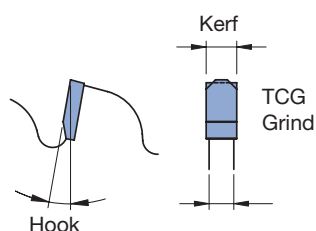
Particleboard and MDF board, with or without plastic, HPL or veneer laminates.

Technical Information:

The cutting width of the scoring saw blade must be identical to the cutting width of the main saw blade.

Product Specifications

D mm	Kerf mm	Bore mm	Teeth	Grind	Driver Element	Driver Dim	Machine	ID#
125	4.4	45	24	ATB Conical			Giben	165553
150	4.4	45	24	ATB Conical			Homag	165557
150	4.4	30	24	ATB Conical			SCM	165556
160	4.4	55	36	ATB Conical	Pins	3/7/66	SCM	165562
160	4.4	25	28	Conical	Pins	3/11/70	Giben	165561
180	4.8	45	36	Conical			Holzma	165634
180	4.4	45	36	Conical			Holzma	165566
180	4.4	30	30	Conical	Pins	2/10/60	Holz-Her	165632
200	5.8	45	34	ATB Conical			Holzma	165575
200	4.8	45	36	Conical			Holzma	165636
200	4.4	45	34	ATB Conical			Holzma	165574
200	4.4	20	34	ATB Conical		2/11/66	Schelling	165569
200	4.8	65	30	ATB Conical	Pins	2/9/110	Selco	165577
200	4.4	65	36	ATB Conical	Pins	2/9/100 + 2/9/110	Selco	165576
215	4.4	50	42	Conical	Pins	3/15/80	Giben	165578



D mm	Kerf mm	Bore mm	Teeth	Grind	Driver Element	Driver Dim	Machine	ID#
300	4.4	75	60	TCG			Homag	163403
350	4.4	60	72	TCG	Pins	2/14/100	Holzma	163409
350	4.4	30	72	TCG	Pins	2/10/60	Schelling/ SCM/Holz-Her	163408
370	4.4	30	72	TCG	Pins	2/10/60	Schelling	163416
380	4.4	60	72	TCG	Pins	2/14/100	Holzma	163418
380	4.8	60	72	TCG	Pins	2/14/100	Holzma	163419
400	4.4	30	72	TCG	Pins	2/10/60	Schelling	163421
400	4.4	80	80	TCG	Pins	2/14/110 + 4/9/100	Gabiani	163455
400	4.4	75	72	TCG			Homag	163423
400	4.4	75	72	TCG	Pins	4/15/105	Giben	163423
400	4.4	80	72	TCG	Pins	2/9/130 + 4/19/120	Selco	163455
420	4.8	60	84	TCG			Holzma	163426
450	4.4	30	72	TCG			Schelling	163430
450	4.8	60	72	TCG	Pins	2/14/125	Holzma	163431
450	4.8	80	72	TCG	Pins	2/9/130 + 4/19/120	Selco	163433
460	4.4	30	72	TCG	Pins	2/13/94	Schelling	163434
500	4.8	60	60	TCG	Pins	2/11/115	Holzma	163440
600	5.8	60	72	TCG	Pins	2/11/115 + 2/19/120	Holzma	163447

1. Sawing

1.5 Industrial Mitre, Optimizing,
Countertop Saw Blades**Mitre and Optimizer Saw Blades****Application:**

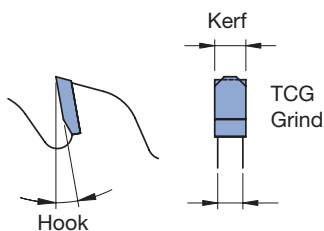
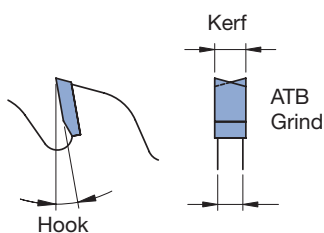
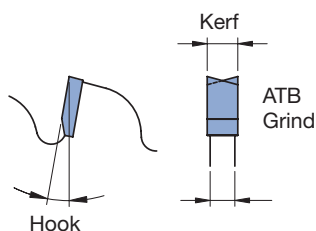
Cross-cutting and optimizing.

Machine:

Chop, up-cut and optimizing saws.

Workpiece Material:

Natural woods.

Product Specifications

D mm	Kerf mm	Bore mm	Teeth	Grind	Hook	Machine	ID#
10"	3.2	5/8"	80	ATB/R	-2°	Pistorius	470043791
12"	2.9	5/8"	80	ATB	-2°	Pistorius	470037924
14"	3.4	5/8"	100	ATB/R	-2°	Pistorius	470038840
16"	4.2	1"	90	ATB	20°	Industrial	470043792
18"	4.2	1"	90	ATB	0°	Whirlwind	470043793
450	5	30	108	ATB	10°	Optimizer	165452
400	3.5	30	120	ATB	10°	Optimizer	57525

Countertop Saw Blades**Application:**

Sizing laminated countertops.

Machine:

Midwest Automation or similar countertop sizing machines.

Workpiece Material:

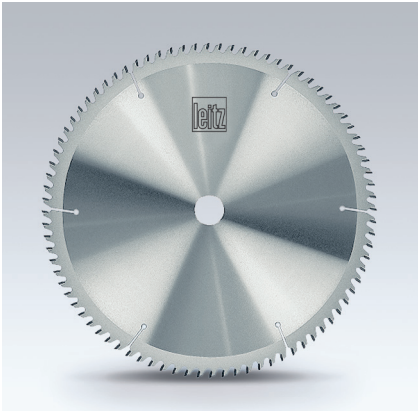
Laminated countertops.

Technical Information:

Designed to cut and protect laminated counter surfaces.

Product Specifications

D	Kerf mm	Bore	Teeth	Grind	Hook	Machine	ID#
16"	4.2	1"	120	TCG	2°	Midwest Automation	156017296
18"	4.2	1"	96	TCG	2°	Midwest Automation	470043794



Non-Ferrous Saw Blades

Application:
Cutting of non-ferrous metals such as aluminum, copper and brass.

Machine:
Cut-off saws.

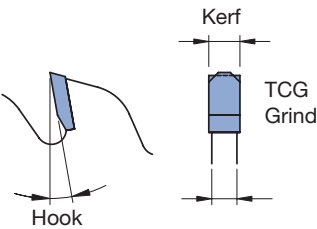
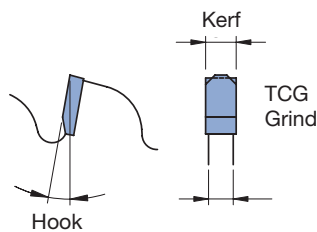
Workpiece Material:
Non-ferrous metals (aluminum, copper, brass, etc.).

Technical Information:
Reinforced tool body for higher stress resistance.



Product Specifications

D mm	Kerf mm	Bore mm	Teeth	Grind	Hook	Application	ID#
300	3.2	30	96	TCG	-5°	Non-Ferrous	60252
350	3.2	30	108	TCG	-5°	Non-Ferrous	60255
400	3.8	30	96	TCG	-5°	Non-Ferrous	60110
500	4.4	30	120	TCG	5°	Non-Ferrous	59874

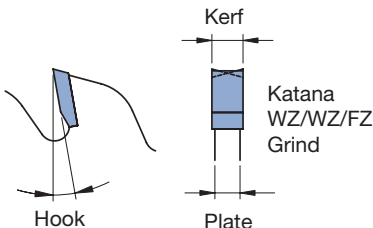
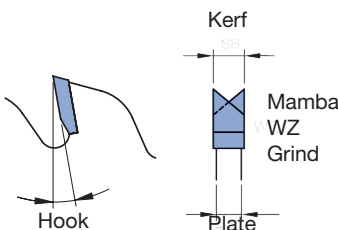
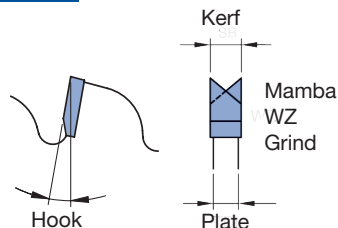


1. Sawing

1.7 Specialty Saw Blades



HW

**Sizing without scoring *Premium* - Mamba****Application:**

For sizing and cross cutting without scoring.

Machine:

Table and sizing saws, vertical panel sizing saws without scoring unit.

Workpiece Material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), thin-walled plastic profiles (thickness < 2 mm), thin-walled plastic honeycomb panels.

Technical Information:

Special WZ with 40° top bevel angle for tear-free cuts on both sides. **Premium** design with combination pinhole pattern vibration-dampening laser ornaments.

Product Specifications**Circular Saw Blade Mamba, negative cutting angle**

WK 880 2

D mm	Kerf mm	Plate mm	Bore mm	NLA	Teeth	Grind	Hook	ID#
250	3.2	2.2	30	KNL	80	WZ	-5°	163225
303	3.5	2.5	30	KNL	96	WZ	-5°	163226

Circular saw blade Mamba, positive cutting angle.

WK 870 2

D mm	Kerf mm	Plate mm	Bore mm	NLA	Teeth	Grind	Hook	ID#
300	3.5	2.5	30	KNL	96	WZ	5°	163200
350	3.5	2.5	30	KNL	108	WZ	5°	163201

Sizing without Scoring *Excellent* - Katana**Application:**

For sizing and cross cutting without scoring.

Machine:

Table and sizing saws, vertical panel sizing saws without scoring unit, cross, trimming and mitre cutting saws.

Workpiece Material:

Solid wood across grain, laminated veneer lumber (e.g. plywood, multiplex plywood), honeycomb panels, thin-walled plastic and non-ferrous metal profiles.

Technical Information:

Katana tooth combination with alternate shear face for best cutting results.

Excellent design with plastic-filled laser ornaments for vibration dampening and reduction of noise level.

Circular Saw Blade Katana, positive cutting angle

WK 870 2

D mm	Kerf mm	Plate mm	Bore mm	NLA	Teeth	Grind	Hook	ID#
255	2.8	2.0	30	KNL	80	WZ/WZ/FZ	10°	161200
303	3.0	2.2	30	KNL	100	WZ/WZ/FZ	10°	161201
355	3.0	2.2	30	KNL	120	WZ/WZ/FZ	10°	161202
400	3.2	2.5	30	KNL	130	WZ/WZ/FZ	20°	161203
450	3.6	2.8	30	KNL	140	WZ/WZ/FZ	20°	161204
500	4.0	3.5	30	KNL	150	WZ/WZ/FZ	20°	161205
550	4.0	3.5	30	KNL	160	WZ/WZ/FZ	20°	161206



Sizing in finish cut quality *Excellent* - BrillianceCut

Application:

For sizing of single sheets and stacked panels without scoring.

Machine:

Table and sizing saws, vertical panel sizing saws, panel sizing saws with pressure beam.

Workpiece Material:

Transparent thermoplastics (e.g. acrylic, PMMA, PC).

Technical Information:

Special tooth geometry for very smooth surfaces and tear-free cutting edges. Recommended saw blade projection 5 to 10 mm. Excellent design with plastic filled laser ornaments for vibration damping and reduction of noise level. Design with positive cutting angle.

Product Specifications

Circular Saw Blade BrillianceCut

WK 371 2

Machine	D mm	Kerf mm	Plate mm	Bore mm	NLA	Teeth	Grind	ID#
Altendorf/Martin/ Streibig	303	3.5	2.5	30	KNL	60	TR/TR	161028
Holz-Her/Höfer/ Langzauner/ Panhans/ Schelling	350	4.4	3.2	30	KNL	72	WZ/FA	161029
Homag	350	4.4	3.2	60	KNL	72	WZ/FA	161030
Homag	380	4.8	3.5	60	KNL	84	WZ/FA	161031
Holz-Her/Panhans/ Scheer/Schelling	400	4.4	3.2	30	KNL	72	WZ/FA	161032
Scheer/Schelling	450	4.4	3.2	30	KNL	72	WZ/FA	161033
Homag	450	4.8	3.5	60	KNL	72	WZ/FA	161034

2. Routing

2.1 Solid Carbide Router Bits



Spiral Finishing Router Bits

Application:

Router cutter for sizing, grooving and finish cutting with chip-free edges.

Machine:

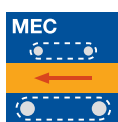
CNC routers, machining centers and point-to-point machines.

Workpiece Material:

Suitable for hardwoods and softwoods, panel products (raw, laminated or veneered) including MDF, particleboard and plywood, solid surface materials and Trespa.

Technical Information:

Alternate shear for chip-free cut edges on both sides. Z2+2 design for coated chipboard material and fibre material, gluelam, abrasive materials and compound materials with aluminum oxide coating.

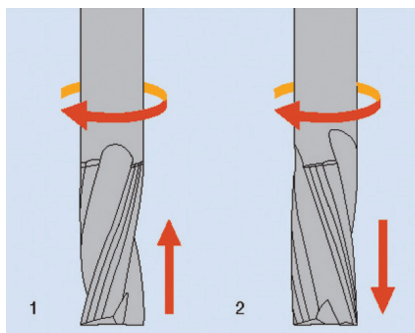


Spiral Finishing Router Bits

Material Application: wood

D	CL	GL	SH	Wings	Qual	Rot	Type	ID#
1/4"	5/8"	2"	1/4"	1	Standard	RH	Up Cut	240512
1/4"	1"	2-1/2"	1/4"	2	Standard	RH	Up Cut	737000119

Spiral cutting edges



1
Up shear, face side on bottom; good chip flow

2
Down shear, face side on top; supports vacuum for small parts

Spiral Finishing Router Bits

Material Application: wood and laminated panels

D mm	CL mm	GL mm	SH mm	Wings	Qual	Rot	Type	ID#
1/8"	1/2"	2"	1/2"	2	Standard	RH	Down Cut	737000138
3/16"	3/4"	2"	1/4"	2	Standard	RH	Down Cut	737000139
3/16"	3/4"	2-1/2"	1/4"	2	Standard	RH	Down Cut	737307055
1/4"	7/8"	2-1/2"	1/4"	2	Standard	RH	Down Cut	737000135
1/4"	1"	2-1/2"	1/4"	2	Standard	RH	Down Cut	737000136
1/4"	1-1/8"	3"	1/4"	2	Standard	RH	Down Cut	737300114
1/4"	1"	2-1/2"	1/4"	2	Standard	RH	Down Cut	240525
3/8"	1-1/8"	3"	3/8"	2	Standard	RH	Down Cut	737000141
3/8"	1-1/4"	3"	3/8"	2	Standard	RH	Down Cut	737000142
1/2"	1-1/8"	3"	1/2"	2	Standard	RH	Down Cut	240519
1/2"	1-1/4"	3-1/2"	1/2"	2	Standard	RH	Down Cut	240511
1/2"	1-1/4"	3"	1/2"	2	Ext Life	RH	Down Cut	240510
1/2"	1-1/8"	3"	1/2"	2	Standard	RH	Down Cut	737300130
1/2"	1-5/8"	3-1/2"	1/2"	2	Standard	RH	Down Cut	737000132
1/2"	2-1/8"	4"	1/2"	2	Standard	RH	Down Cut	737000134
5	20	64	6	2	Standard	RH	Down Cut	737303515
1/2"	1-5/8"	3-1/2"	1/2"	2	Ext Life	RH	Down Cut	240527
1/2"	7/8"	3"	1/2"	2	MC	RH	Down Cut	737313122

2. Routing

2.1 Solid Carbide Router Bits



Spiral Finishing Router Bits

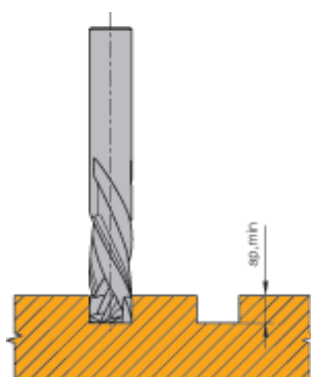
Material Application: wood, plastic and solid surface

D	CL	GL	SH	Wings	Qual	Rot	Type	ID#
1/2"	1-1/8"	3-1/2"	1/2"	3	Ext Life	RH	Up Cut F	240509

Compression Router Bits

Material Application: laminated panels

D	CL	GL	SH	Wings	Qual	Rot	Up Cut	ID#
1/4"	7/8"	2-1/2"	1/4"	2/2	Standard	RH	.413"	240528
1/2"	1-1/8"	3"	1/2"	2/2	Standard	RH	.512"	240521
1/2"	1-3/8"	3-1/2"	1/2"	2/2	Standard	RH	.669"	240522
1/2"	1-5/8"	4"	1/2"	2/2	Standard	RH	.748"	240523
1/2"	1-1/2"	3-1/2"	1/2"	2/2	Ext Life	RH	.472"	240517
1/2"	1-5/8"	4"	1/2"	2/2	Ext Life	RH	.748"	240507
1/2"	1-5/8"	4"	1/2"	2/2	MC	RH	.750"	737312793
3/8"	1-1/8"	3"	3/8"	2/2	Ext Life	RH	.406"	737308635
3/8"	1-1/8"	3"	3/8"	3/3	MC	RH	.406"	737315170
3/4"	2-1/4"	5"	3/4"	2/2	Ext Life	RH	1"	737308644



Minimum grooving depth ap min for tear-free cut.

Mortise Compression Router Bits

Material Application: laminated panels

D	CL	GL	SH	Wings	Qual	Rot	Up Cut	ID#
1/4"	7/8"	2-1/2"	1/4"	2/2	Standard	RH	.256"	240526
1/2"	7/8"	3"	1/2"	2/2	PLR	RH	.200"	737317056
1/2"	1-3/8"	3-1/2"	1/2"	3/3	Standard	RH	.276"	240524
3/8"	7/8"	3"	3/8"	2/2	Ext Life	RH	.177"	240518
3/8"	7/8"	3"	3/8"	2/2	PLR	RH	.188"	737316940
3/8"	1-1/8"	3"	3/8"	2/2	Ext Life	RH	.236"	240516
3/8"	1-1/8"	3"	3/8"	2/2	Ext Life	RH	.244"	240503
1/2"	1-1/4"	3"	1/2"	2/2	Ext Life	RH	.114"	240504
1/2"	1-1/4"	3"	1/2"	2/2	Ext Life	RH	.127"	240505
1/2"	1-3/8"	3-1/2"	1/2"	2/2	Ext Life	RH	.197"	240506
3/8"	7/8"	3"	3/8"	3/3	Ext Life	RH	.177"	240508
1/4"	7/8"	2-1/2"	1/4"	2/2	Ext Life	RH	.188"	737314754
3/8"	7/8"	3"	3/8"	2/2	Ext Life	RH	.188"	737304397
1/4"	7/8"	2-1/2"	1/2"	2/2	MC	RH	.188"	737318063
3/8"	7/8"	3"	3/8"	2/2	MC	RH	.200"	737312357
1/2"	1-3/8"	3-1/2"	1/2"	2/2	MC	RH	.625"	737312707
1/2"	1-3/8"	3-1/2"	1/2"	2/2	MC	RH	.200"	737312819
3/8"	7/8"	3"	3/8"	3/3	MC	RH	.200"	737312646
1/2"	1-3/8"	3-1/2"	1/2"	3/3	MC	RH	.200"	737313067
1/2"	1-3/8"	2-1/2"	1/2"	2/2	Ext Life	RH	.200"	737310544

2. Routing

2.1 Solid Carbide Router Bits



Low Helix Finisher

Material Application: natural wood, plastics, composite plastics, solid surface

D	CL	GL	SH	Wings	Qual	Rot	ID#
1/4"	7/8"	3"	1/4"	3	Standard	RH	737300053
1/2"	1-1/8"	3-1/2"	1/2"	3	Standard	RH	737300056

Carbide Chipbreaker Finisher

Material Application: natural wood, wood composites

D	CL	GL	SH	Wings	Qual	Rot	ID#
1/2"	1-1/8"	3"	1/2"	2	Standard	RH	737300540
1/2"	1-1/2"	3-1/2"	1/2"	2	MC	RH	240515
1/2"	1-1/8"	3"	1/2"	2/2	Standard	RH	737300334
3/8"	7/8"	3"	3/8"	2/2	Standard	RH	737300472

O-Flute Straight Router Bits

Material Application: plastics

D	CL	GL	SH	Wings	Qual	Rot	ID#
3/16"	1"	4"	1/4"	1	Standard	RH	737307219
1/4"	3/4"	2-1/2"	1/4"	1	Standard	RH	737300511

O-Flute Router Bits

Material Application: hard plastics

D	CL	GL	SH	Wings	Qual	Rot	Type	ID#
1/8"	1/2"	2"	1/4"	1	Standard	RH	Up Cut	737300017
3/16"	5/8"	2-1/2"	1/4"	1	Standard	RH	Up Cut	737300200
3/8"	1-1/8"	3"	3/8"	1	Standard	RH	Up Cut	737300203

Carbide Spiral Wood Up Cut

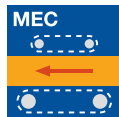
Material Application: soft plastics

D	CL	GL	SH	Wings	Qual	Rot	Type	ID#
3/4"	2-1/8"	4"	3/4"	2	Standard	RH	Up Cut	737300615
3/8"	1"	3"	3/8"	2	Standard	RH	Up Cut	737308096

Spiral Finishing Router Bits

Material Application: phenolic panels

D	CL	GL	SH	Wings	Qual	Rot	Type	ID#
1/2"	1-1/8"	3"	1/2"	3	Ext Life	RH	Up Cut	737301577



DiaMaster PRO 1+1 Router Bits

Application:

Diamaster (PCD) tools offer extended performance and efficient sizing and nesting cuts in panel products and abrasive materials.

Machine:

CNC routers.

Workpiece Material:

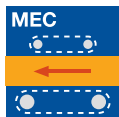
Particle and MDF board, raw or laminated with plastic, HPL or veneer and corresponding backer boards.

Technical Information:

1+1 wing PCD design for slower processing speeds and greatly increased service life as compared to solid carbide.

Product Specifications

Description	D	CL	GL	SH	ID#
PRO Z1+1	1/2"	7/8"	2-3/4"	1/2"	91296
PRO Z1+1	1/2"	1-3/8"	3-1/8"	1/2"	191065
PRO Z1+1	3/4"	1-1/4"	3-3/4"	3/4"	191066
PRO Z1+1	3/4"	1-7/8"	4-3/8"	3/4"	91297



DiaMaster PRO 2+2 Router Bits

Application:

Diamaster (PCD) tools offer extended performance and efficient sizing and nesting cuts in panel products and abrasive materials.

Machine:

CNC routers.

Workpiece Material:

Particle and MDF board, raw or laminated with plastic, HPL or veneer and corresponding backer boards.

Technical Information:

2+2 wing PCD design for fast processing speeds and greatly increased service life.

Product Specifications

Description	D	CL	GL	SH	ID#
PRO Z2+2	3/8"	13/16"	2-9/16"	3/8"	191062
PRO Z2+2	1/2"	15/16"	2-3/4"	1/2"	191063
PRO Z2+2	1/2"	1-1/8"	2-15/16"	1/2"	191064
PRO Z2+2	1/2"	1-1/2"	3-11/32"	1/2"	191103
Quattro Z2+2	3/4"	1-3/4"	4"	3/4"	191068
Panel Groover, Z=2	1/2"	1/2"	3"	1/2"	191067

2. Routing

2.2 Diamond Router Bits



DiaMaster PRO 3+3 Router Bits

Application:

Diamaster (PCD) tools offer extended performance and efficient sizing and nesting cuts in panel products and abrasive materials.

Machine:

CNC routers.

Workpiece Material:

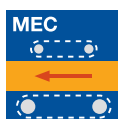
Particle and MDF board, raw or laminated with plastic, HPL or veneer and corresponding backer boards.

Technical Information:

3+3 wing PCD design for fastest processing speeds and greatly increased service life.

Product Specifications

Description	D	CL	GL	SH	ID#
PRO Z3+3	1/2"	15/16"	2-3/4"	1/2"	191057
PRO Z3+3	1/2"	1-1/8"	2-15/16"	1/2"	191058



DiaMaster EdgeExpert Router Bits

Application:

Diamaster (PCD) EdgeExpert router bits offer unmatched performance in sizing and grooving applications and yield tear-free edges on both workpiece sides with sensitive laminates, foils and veneers.

Machine:

CNC routers.

Workpiece Material:

Particle and MDF board, raw or laminated with plastic, HPL or veneer.

Technical Information:

From 1+1 up to 3+3 wing PCD design for fastest possible processing speeds. Shrink fit chucks highly recommended. 18K to 24K rpm. EdgeExpert router bits perform at their best when used in combination with a pre-sizing tool.

Product Specifications

Description	D	CL	GL	SH	ID#
EdgeExpert PRO Z1+1	5/8"	1"	3-11/32"	5/8"	191076
EdgeExpert PRO Z1+1	5/8"	1-3/8"	3-3/4"	5/8"	191077

Recommended feed speed: 215-355 ipm at 24,000 rpm depending on material.

EdgeExpert Quattro Z2+2	3/4"	1-1/4"	3-35/64"	3/4"	191078
-------------------------	------	--------	----------	------	--------

Recommended feed speed: 425-710 ipm at 24,000 rpm depending on material.

EdgeExpert PLUS Z3+3	1"	1-3/8"	4-1/32"	1"	191081
----------------------	----	--------	---------	----	--------

Recommended feed speed: 635-1,065 ipm at 24,000 rpm depending on material.



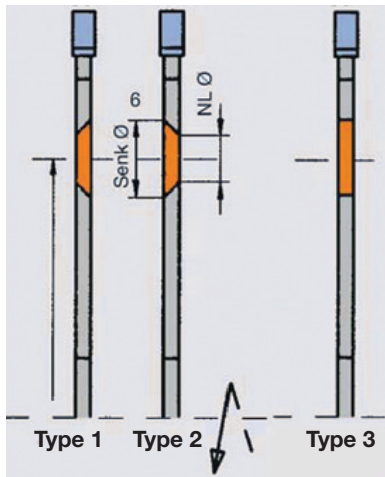
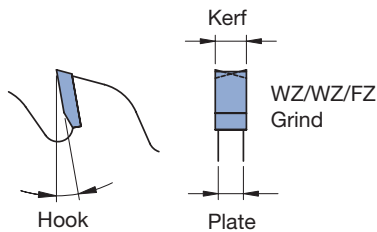
Grooving on CNC machining centers

Application:
For grooving.

Machine:
Aggregates on CNC machining centers.

Workpiece Material:
Laminated and raw panels (e.g. particleboard, MDF, plywood, melamine and HPL).

Technical Information:
Tooth configuration WZ/WZ/FZ for chip-free grooves. Mounted on aggregate flanges.



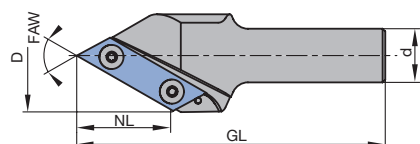
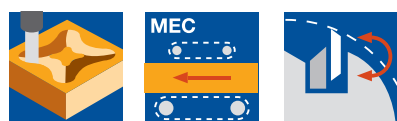
- Type 1:**
Countersink right
- Type 2:**
Countersink left
- Type 3:**
Pinhole without countersink

Grooving saw blade WZ/WZ/FZ for CNC
WK 859 2

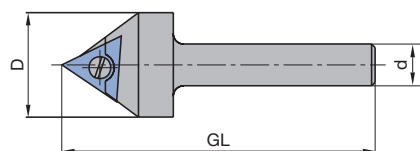
D mm	Kerf mm	Plate mm	Bore mm	Type	Teeth	Grind	Hook	Machine	ID#
100	3.5	2.5	30		35	WZ/WZ/FZ	15°	Weeke	166000
100	4.0	2.8	30		35	WZ/WZ/FZ	15°	Weeke	166008
100	5.0	3.5	30		35	WZ/WZ/FZ	15°	Weeke	166001
120	3.5	2.5	20	3	35	WZ/WZ/FZ	15°	SCM/ Morbidelli	166002
120	3.5	2.5	35	2	35	WZ/WZ/FZ	15°	Biesse	166004
120	4.0	2.8	20	3	35	WZ/WZ/FZ	15°	SCM/ Morbidelli	166009
120	4.0	2.8	35	2	35	WZ/WZ/FZ	15°	Biesse	166010
120	5.0	3.5	20	3	35	WZ/WZ/FZ	15°	SCM/ Morbidelli	166003
120	5.0	3.5	35	2	35	WZ/WZ/FZ	15°	Biesse	166005
125	3.5	2.5	30	1, 2	35	WZ/WZ/FZ	15°	Homag/ Weeke	166006
125	4.0	2.8	30	1, 2	35	WZ/WZ/FZ	15°	Homag/ Weeke	166011
125	5.0	3.5	30	1, 2	35	WZ/WZ/FZ	15°	Homag/ Weeke	166007

2. Routing

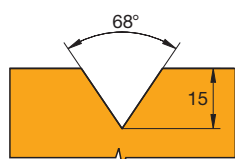
2.4 V-grooving, Finishing Cutters



V-groove cutter (Profile #2-5)



V-groove cutter 68° (Profile #1)



V-groove cutter in turnblade design with point 68° (ID# 42932)

Turnblade finishing cutter, Z1

Application:

For machining V-groove profiles and for multi-purpose carving operations (decorative groove, 90° corner etc.).

Machine:

CNC routers and machining centers.

Workpiece Material:

Softwood and hardwood, chipboard and fiber materials (MDF, HDF, etc.), uncoated, plastic coated, veneered, etc., laminated veneer lumber (plywood, multiplex, plywood etc.).

Technical Information:

Cutterhead with turnblade knives. Extra long design (ID 42937) particularly suitable for carving operations on 5-axis machines. The 60° and 68° version is best suited for corner squaring applications.

HW, Z1

WL 300 2

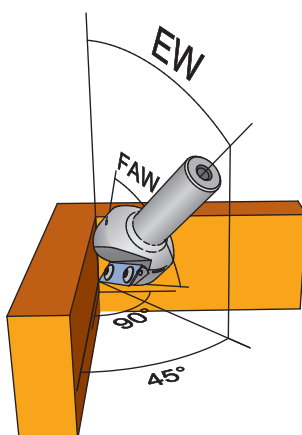
D mm	GL mm	CL mm	SH mm	Bevel	Teeth	Profile #	Rot	ID#
29	90	15	12 x 40	68°	1	1	RH	42932
35	125	42	20 x 50	45°	1	2	RH	42933
42	115	35	20 x 50	60°	1	3	RH	42934
42	180	35	20 x 50	60°	1	3	RH	42937
54	100	27	20 x 50	90°	1	4	RH	42935
54	100	27	20 x 50	91°	1	5	RH	42936

Spare Knives

Description	Dimensions mm	Profile #	Qual	ID#
Turnblade Knife Triangular	19 x 9 x 2	1	HW	9528
Turnblade Knife	59 x 12 x 1.5	2	HW	602503
Turnblade Knife	49 x 12 x 1.5	3	HW	602502
Turnblade Knife	39 x 12 x 1.5	4/5	HW	602501

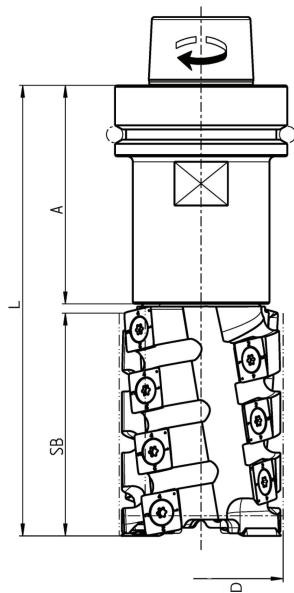
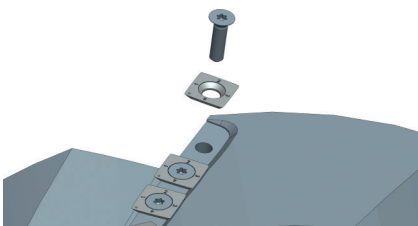
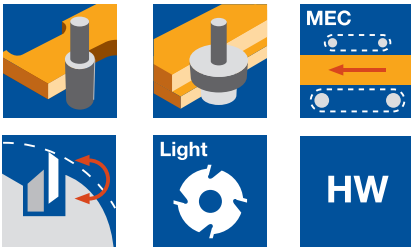
Spare Parts

Description	Dimensions mm	Profile #	Qual	ID#
Countersink Screw	M 5 x 5	1		7381
Oval Head Screw Torx® 15	M 4 x 5	2-5		7038
Torx® Wrench/Driver	Torx® 15	2-5		5457



Adjustment angle, EW, depending on the bevel angle; FAW for squaring 90° inside corners.

FAW	EW
45°	= 32.77°
60°	= 45.00°
68°	= 52.26°



Copy shaping cutterhead - HeliCut 15

Application:

For pre-cutting and jointing of large cutting depths, MCL arched parts along and across the grain. For pre-cutting.

Machine:

Spindle CNC routers and machining centers.

Workpiece Material:

Softwood and hardwood, glulam and laminated wood.

Technical Information:

Low-noise design with staggered knives, shear cut and spurs for rebating. Designed with numbered knife edges and without clamping wedges for quick and easy knife changes. By default, mounted with HW turnblade knives ID **9543**.

Copy shaping cutterhead - HeliCut 15

WL 300 2

D mm	SB mm	Shank	L mm	# of Knives	Teeth	Spurs	ID#	Variant ID#
60	81.5	HSK-F 63	165	16	2/2	2 bottom	132736	110001
60	81.5	HSK-F 63	130	16	2/2	2 bottom	132736	110003
80	81.5	HSK-F 63	165	16	2/2	2 bottom	132737	110001
80	81.5	HSK-F 63	130	16	2/2	2 bottom	132737	110003
125	93.7	HSK-F 63	173.2	20	2/2	2+2 top & bottom	132738	110001
125	93.7	HSK-F 63	138.2	20	2/2	2+2 top & bottom	132738	110003

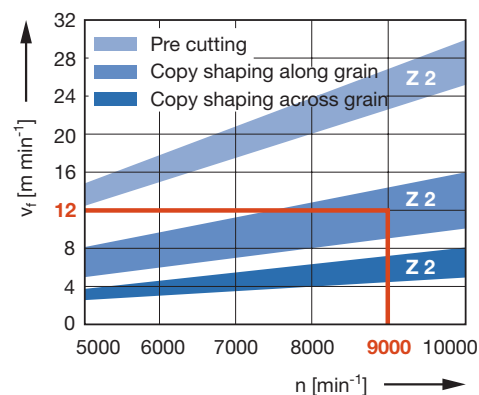
RPM: D 60 mm: $n_{\max} = 20,000 \text{ min}^{-1}$
 D 80 mm: $n_{\max} = 18,000 \text{ min}^{-1}$
 D 125 mm: $n_{\max} = 12,000 \text{ min}^{-1}$

Spare Knives

Description	Dimensions mm	Qual	Desc 2	Sales Unit	ID#
Turnblade Knife	15 x 15 x 2.5	HW	HeliCut 15	10	9549
Turnblade Knife	15 x 15 x 2.5	HW-MF	HeliCut 15	10	9543

Spare Parts

Description	D mm	ID#
Countersink Screw, Torx® 20	M5 x 18	114030
Torx® Wrench/Driver	Torx® 20	6091



Feed speed v_f depending on the number of teeth Z and speed n for solid wood (pre trimming and copy shaping)

Example:

$n = 9000 \text{ min}^{-1}$, $Z 2$ /copy shaping along the grain: $v_f = 12 \text{ m min}^{-1}$

2. Routing

2.6 MDF Doors



Leitz MDF Door Program

Leitz offers precision tooling to create thermofoil doors. Mix and match profiles to make a wide variety of door designs.

With standard profiles and customized profiles available, you can efficiently and affordably create MDF doors that exceed your customer's expectations.

Nesting tools for MDF door manufacturing

- Contemporary profiles
- ZZ DP PLUS router bit design for 6 to 8 sharpenings for most shapes
- Z1 DP PRO router bit design finishing tools for acute corners
- 3/4" shank suitable for use with standard HSK-63 F and SK30 ThermoGrip chucks
- Plunging tip for axial plunging
- Custom profiles available

Product Specifications

5/8" Thick MDF Doors, Outside Edge Profiles

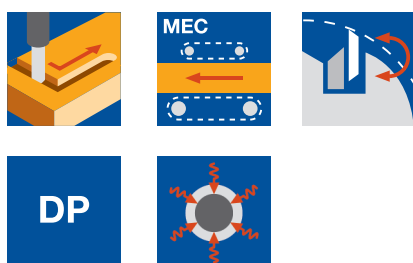
Profile	D Zero	Wings	SH	ID#
R 1/16" Outside Edge	3/4"	2	3/4"	130077062
R 1/8" Outside Edge	3/4"	2	3/4"	130079871
R 1/4" Outside Edge	3/4"	2	3/4"	130077077
R 3/8" Outside Edge	3/4"	2	3/4"	130077082
45° Bevel Outside Edge	3/4"	2	3/4"	130077089
1/4" Waterfall	1/2"	2	3/4"	130077053

3/4" Thick MDF Doors, Outside Edge Profiles

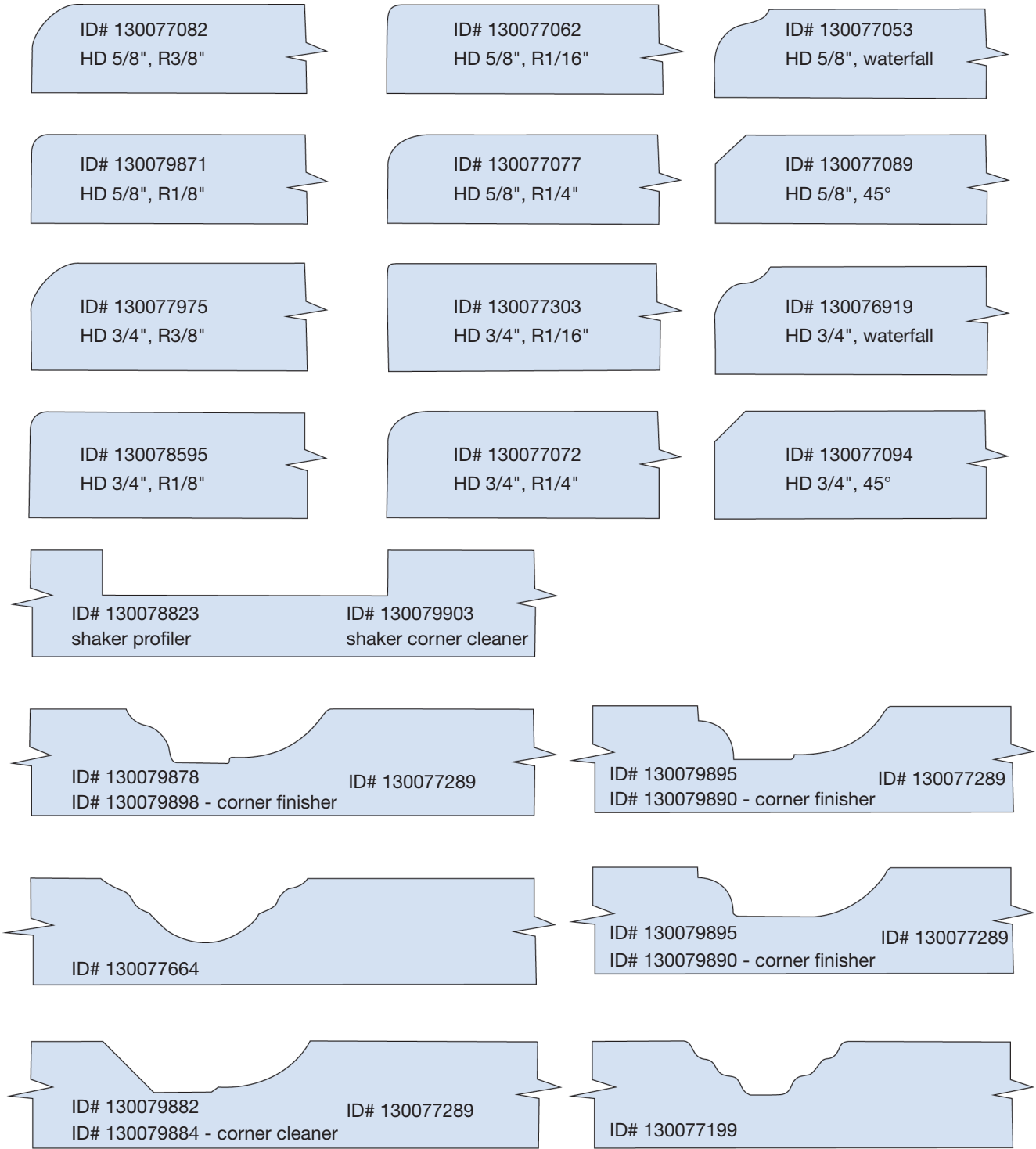
Profile	D Zero	Wings	SH	ID#
R 1/16" Outside Edge	3/4"	2	3/4"	130077303
R 1/8" Outside Edge	3/4"	2	3/4"	130078595
R 1/4" Outside Edge	3/4"	2	3/4"	130077072
R 3/8" Outside Edge	3/4"	2	3/4"	130077975
45° Bevel Outside Edge	3/4"	2	3/4"	130077094
1/4" Waterfall	3/4"	2	3/4"	130076919

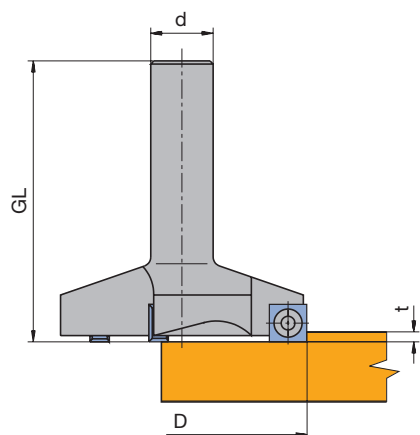
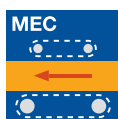
Center Panels for MDF Doors

Profile	D Zero	Wings	SH	ID#
Shaker Panel Hogger	3/4"	2	3/4"	130078823
Bead Rail	3/4"	2	3/4"	130079895
Scoop Panel	3/4"	2	3/4"	130077289
Bevel Rail	3/4"	2	3/4"	130079882
Waterfall	3/4"	2	3/4"	130077199
Contemporary	3/4"	2	3/4"	130077664
Ogee Rail	3/4"	2	3/4"	130079878
Cleaner Shaker Corner	1/2"	2	3/4"	130079903
Cleaner Ogee Corner	3/4"	1	3/4"	130079898
Cleaner Bead Corner	3/4"	1	3/4"	130079890
Cleaner Bevel Corner	3/4"	1	3/4"	130079884



Standard Profiles





t = 0.5-10 mm
 Surface planing during nesting:
 t = 0.5-1.5 mm
 ID 041552 n = 8,400 rpm
 Vf = 25-40 m/min

Fly Cutters - Turnblade Design

Application:

For surface planing materials (such as spoilboards) or recessing of large workpieces.

Machine:

CNC routers.

Workpiece Material:

Suitable for processing softwood, hardwood, plywood, chipboard, MDF, with or without laminated or veneered surfaces.

Technical Information:

Equipped with replaceable 4-sided inserts, with or without radius corners, for exceptional finish quality in solid woods and MDF.

Product Specifications

HW, Z3, Z4, Z5
 WL 400 2

D mm	GL mm	CL mm	SH mm	Wings	Rot	Style	Insert Style	ID#
2.5"	2-3/4"	14	1/2"	2	RH	Straight	Type A	130079262
2.5"	2-3/4"	14	1/2"	2	RH	Up-shear	Type A	130079258
2.5"	2-3/4"	15	1/2"	3	RH	Radius*	Type B	130079260
4"	2-7/8"	14	3/4"	3	RH	Up-shear	Type A	130079222
4"	2-7/8"	14	3/4"	3	RH	Straight	Type A	130079224
4"	2-7/8"	15	3/4"	3	RH	Radius*	Type B	130079226
80	90	15	20 x 50	3	RH	Straight	Type B	41554
80	100	15	25 x 50	3	RH	Straight	Type B	41555
135	90	15	2 x 50	4	RH	Straight	Type B	41556
180	90	15	25 x 50	5	RH	Straight	Type B	41557

*Radius edges for exceptional plastic and aluminum surfacing.

Spare Parts

Description	Dimensions	Insert Style	ID#
Torx® Screw	M5 x 12.9	Type A & B	7808
Insert Type A	14 x 14 x 2	Type A	5099
Insert Type B	15 x 15 x 2.5	Type B	9535
Wrenches	T20	Type A & B	6091

2. Routing

2.8 Beveling Tools



Adjustable Bevel Cutterhead

Application:

For jointing, beveling and raised panels with stepless adjustable bevel angles $\pm 60^\circ$.

Machine:

Stationary routers with/without CNC control, machining centers.

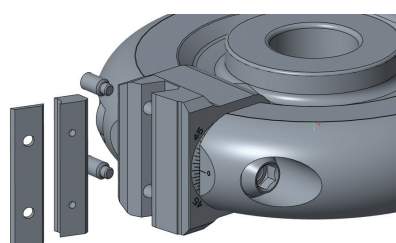
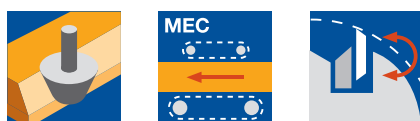
Technical Information:

Quick adjustment to typical angles 15° , 30° , 45° , and 60° with positive stop. Other intermediate angles via bezel scale.

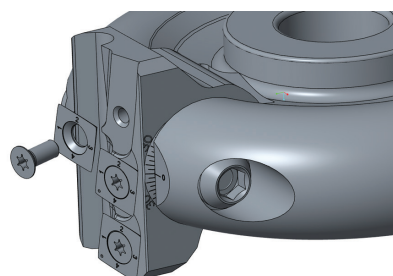
Insert design: 2-edged conventional carbide inserts suitable for a wide range of materials. Maximum material thickness 34 mm @ 45° .

HeliCut design: 4-edge carbide inserts with aggressive alternative shear geometry, particularly suitable for solid wood and soft materials. Maximum material thickness 38 mm @ 45° .

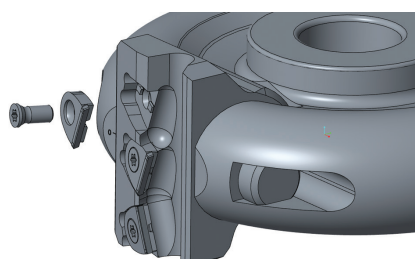
WhisperCut design: 1-edge diamond inserts with alternative shear for chip-free edges, top and bottom, particularly well-suited for abrasive materials.



Insert Design



HeliCut Design



WhisperCut Design

Beveling Tools

Desc of Cutterhead	D mm	Kerf mm	SH mm	Wings	Rot	Knife Material	ID#
Insert	120	50	25 x 60	2+2	RH	HW	42864
Insert	120	50	20 x 60	2+2	RH	HW	42865
HeliCut	120	57	25 x 60	1+1	RH	HW	42859
HeliCut	120	57	20 x 50	1+1	RH	HW	42863
WhisperCut	120	57	25 x 60	1+1	RH	DP	42860
WhisperCut	120	57	20 x 60	1+1	RH	DP	42866

Insert adjustable bevel spare parts and knives

Description	Dimensions mm	Qual	Sales Unit	ID#
Turnblade Knife	50 x 12 x 1.5	HW-05F	10	5086
Clamping Wedge with Pin	38 x 10.88 x 6			5348
Allen Screw	M6 x 12			6035
Allen Key	SW 8, L100			5437
Allen Key	SW 3			5433
Setting Gauge for Knives	80 x 12 x 9.5			5352

WhisperCut adjustable bevel spare parts and knives

Description	Dimensions mm	ID#
WhisperCut Knife SB14	14 x 14.2 x 4.3	91074
Countersink Screw, Torx® 20/59°	M5 x 11.5	7899
Torx® Key	Torx® 20	6091
Allen Key	SW 8, L 100	5437

HeliCut adjustable bevel spare parts and knives

Description	Dimensions mm	ID#
Turnblade Knife	15 x 15 x 2.5	9543
Countersink Screw, Torx® 20	M5 x 12	7898
Torx® Key	Torx® 20	6091
Allen Key	SW 8, L 100	5437

2. Routing

2.9 Chucks, Collets, Heat Shrink Units



2.9.1 Chucks



Collet Chucks

HSK-F 63 Collet Chuck

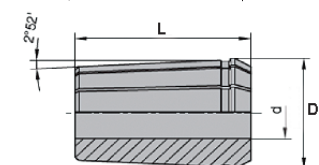
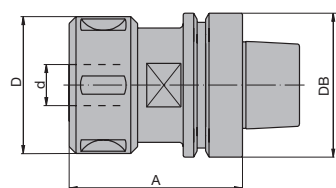
Precision conventional clamping for cylindrical shank tools with shanks from 6mm to 25.4 mm. HSK-F 63 hollow taper design per DIN 69893. Precise concentricity with hardened, ground, double-slit collets. Easy tool handling as collets open automatically when loosening the collet nut. Ball bearing collet nut for increased clamping torque and improved concentricity compared to one-piece design. Tool body and nut precision balanced to 30,000 rpm.

Product Specifications

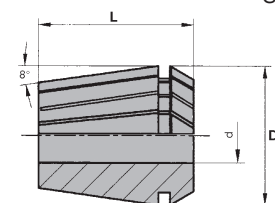
Collet Chucks

Uses Collet Type	D mm	d mm	A mm	DB mm	Weight kg	ID# RH
SYOZ25	63	6-25.4	76	63	1.1	37412
SYOZ25	63	6-25.4	76	63	1	130049937*
ER40	63	6-25.4	76	63	1	37970
ER32	50	6-20	65	63	0.85	679041

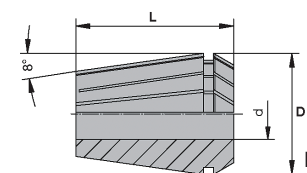
*With limited slip collet nut, G2.5 balance.



SYOZ25/RD035



ER 40 collet



ER 32 collet

Collets

Collet Types

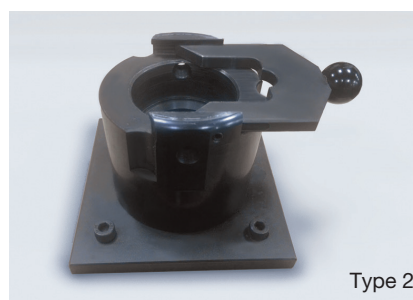
ER 25		ER 32		ER 40		SYOZ25	
D	L	D	L	D	L	D	L
26 mm	34 mm	33 mm	40 mm	41 mm	46 mm	35.05 mm	52 mm
d mm	ID#	d mm	ID#	d mm	ID #	d mm	ID#
1/4"	679027	1/4"	37509	1/8"	737317972	1/8"	37519
3/8"	679028	3/8"	37510	1/4"	37934	1/4"	37495
1/2"	679029	1/2"	37511	3/8"	37935	3/8"	37505
5/8"	679030	5/8"	37507	1/2"	39736	1/2"	37496
		3/4"	37506	5/8"	37937	5/8"	37502
		20 mm	37447	3/4"	37938	3/4"	37497
				20 mm	37932	20 mm	37437
				25 mm	37933	25 mm	37438

Spare Parts

Description 1	Dimensions	Description 2	ID#
Collet Wrench		For D63 collet nut	5458
Collet Wrench		For D50 collet nut	5491
SYOZ25	M48 x 2	Collet nut with bearing	5714
SYOZ25	M48 x 2	Collet nut with limited slip	130046715
ER40	M50 x 1.5	Collet nut with bearing	6639
ER32	M40 x 1.5	Collet nut with bearing	5718
Mounting Stand for HSK-F 63		Type 2	79003
Mounting Stand for HSK-F-63		Type 1	79009
Torque Wrench Handle	60-150 ft/lbs		737317508
Adapter ER32			737317830
Adapter ER40, SYOZ25			737317850



Type 1



Type 2



ThermoGrip® Tool Holders & Heat Shrink Units

SK30 ThermoGrip® Tool Holders

Tool clamping for high performance. Fine balanced to 36,000 rpm and ideal for high-speed machining. Short, slim design for improved chip flow and dust extraction. Suitable for solid carbide and steel shanked tools. Clamping excentricity, $e < 0.01$ mm. ThermoGrip® provides the most stable and rigid clamping technology for increased feed rate and tool performance of any available clamping system.

Product Specifications

HSK-F 63 ThermoGrip® Chuck

D mm	d mm	A mm	DB mm	Weight kg	Shank Tolerance	ID#
27	1/4"	75	63	0.8	h6	130054492
32	3/8"	75	63	0.9	h6	670010
34	1/2"	75	63	0.9	h6	670011
34	5/8"	75	63	0.9	h6	130077168
42	3/4"	75	63	1	h6	670012
42	1"	75	63	0.9	h6	737314406
42	20	75	63	1	g6	37710
42	25	75	63	0.9	g6	37711

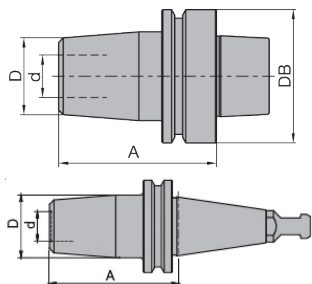
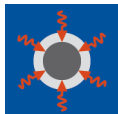
SK30 ThermoGrip® Chuck

D mm	d mm	A mm	DB mm	Weight kg	Shank Tolerance	ID#
34	1/2"	70	63		h6	737314547
42	20	70	63		g6	670205
42	25	80	63		g6	670211

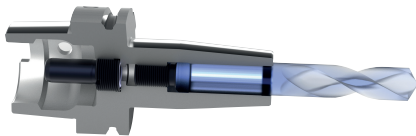
ISO30 FOR CMS ThermoGrip® Chuck

D mm	d mm	A mm	DB mm	Weight kg	Shank Tolerance	ID#
34	1/2"	70	50		h6	737314836*

*Does not include pull stud.



Induction Unit: ISG3400



ThermoGrip CNC chuck system



Leitz Turbine

Leitz Turbine creates powerful suction which cleans the machining area in CNC equipment while you route and nest, reducing dust significantly. It is used in conjunction with the ThermoGrip CNC chuck system which provides the most rigid link between the machine spindle and cutting tool. Rigid tool holding and optimized dust collection allow for the fastest possible routing while maintaining a clean work environment.

Description	Tool Shank mm	ID#
HSK-63F Turbine	12	737315209
HSK-63F Turbine	1/2"	737315813
HSK-63F Turbine	3/8"	737315871
HSK-63F Turbine	3/4"	737315872

2. Routing

2.10 CNC Saw Flanges



CNC Saw Flange Short

Application:

Saw flange for CNC application.

Technical Information:

Various saw blades, flush-mounted or with counterflange. For increased stability and concentricity. Maximum diameter of saw blade is 350 mm.

Product Specifications

HSK-F63, DIN 69893

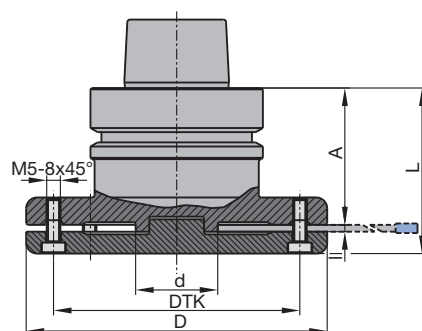
TI 501 0 07

Machine	A mm	d mm	D mm	l_{max} mm	TK	L mm	Weight kg	ID#
Homag	40	30	110	3.5	90	75.5	2.0	663094
	50	30	110	3.5	90	85.5	2.2	663093
SCM	60	30	110	3.5	90	95.5	2.5	663109

Consists of HSK-flange with countersink screws, counter flange and caphead screws.

Spare Parts

Description	Dimensions	ID#
Caphead Screw with ISK	M5 x 12	6414
Countersink Screw, Torx® 20	M5 x 8.5	7808
Allen Key	SW 4, L 71	5468
Torx® Key	Torx® 20	11751



Clamping flange with or without counter flange



CNC Saw Flange Long

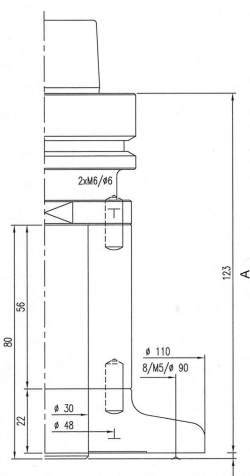
Application:

Flange and arbor assembly for 5-axis saw blades.

Technical Information:

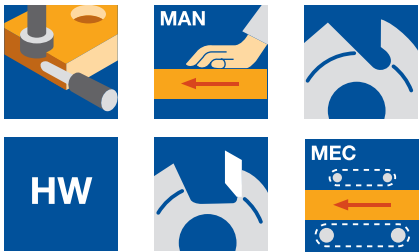
Various flush-mounted saws for space-saving, nested tool applications. The overall length reflected in the variant ID# is **built to order**. Maximum saw diameter is 350 mm. Saws may require additional pin holes, 8NLA for M5 Torx® screw/90 mm bolt circle.

Machine	A mm	d mm	D mm	SH	Variant ID#	ID#
5-axis CNC	123	30	110	HSK-63F	10123	735111170
5-axis CNC	158	30	110	HSK-63F	10158	735111170

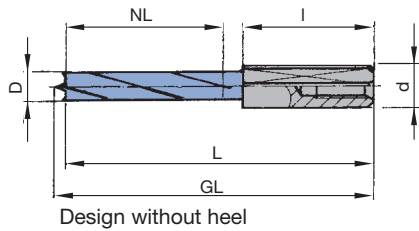


3. Drilling

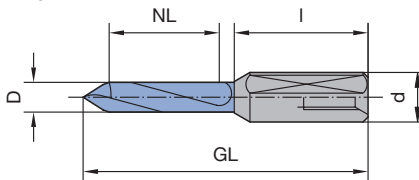
3.1 Dowel, V-Point, Hinge Drill Bits



Dowel



V-point



Drill Bits

Application:

For drilling sharp, precision hinge and dowel holes for furniture and cabinets.

Machine:

Point-to-point machines, through-feed boring machines, CNC machining centers, hinge boring machines, multi-spindle units.

Workpiece Material:

Softwood and hardwood, chipboard and fiber materials (MDF, HF, etc.), raw, laminated and/or veneered panels.

Solid carbide design, rigid with polished shank to reduce friction for easier drilling and zero-clearance head to eliminate chipping on the return stroke. Elliptical spurs and knife geometry for longer life in panel processing applications.

Product Specifications

D mm	Type	CL mm	GL mm	SH mm	ID# LH	ID# RH
5	Dowel	25	57.5	10 x 27	33728	33729
8	Dowel	25	57.5	10 x 27	33732	33733
10	Dowel	25	57.5	10 x 27	33786	33787
5	V-point	25	57.5	10 x 27	34018	34019
8	V-point	25	57.5	10 x 27	34022	34023
3	Dowel	16	70	10 x 45	42596	42597
5	Dowel	35	70	10 x 24	33496	33497
8	Dowel	35	70	10 x 24	33500	33501
10	Dowel	35	70	10 x 24	33540	33541
5	V-point	35	70	10 x 24	34100	34101
8	V-point	35	70	10 x 24	34104	34105
10	V-point	35	70	10 x 24	34114	34115

Economical, carbide-tipped design with conventional spur and V-point geometry suitable for panel processing applications, without heel.

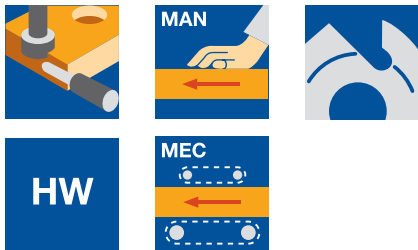
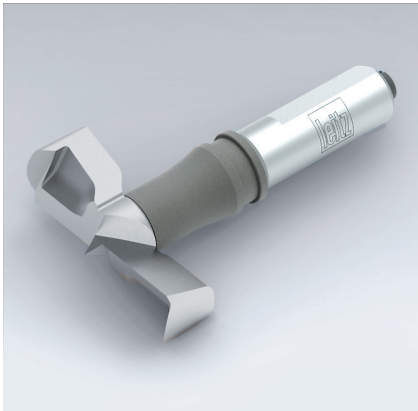
Product Specifications

D mm	Type	CL mm	GL mm	SH mm	ID# LH	ID# RH
3	Dowel	16	57.5	10 x 27	33610	33611
5	Dowel	25	57.5	10 x 27	33672	33673
8	Dowel	25	57.5	10 x 27	33682	33683
10	Dowel	25	57.5	10 x 27	33690	33691
5	V-point	25	57.5	10 x 27	34000	34001
8	V-point	25	57.5	10 x 27	34002	34003
5	Dowel	35	70	10 x 24	33440	33441
8	Dowel	35	70	10 x 24	33446	33447
10	Dowel	35	70	10 x 24	33448	33449
5	V-point	35	70	10 x 24	34074	34075
8	V-point	35	70	10 x 24	34076	34077
10	V-point	35	70	10 x 24	34110	34111

Optional setting screw for quick change system ID# 9157.

3. Drilling

3.1 Dowel, V-Point, Hinge Drill Bits



Drill Bits

Solid carbide hinge drill bits are designed with large, open gullets for high-speed drilling and optimal chip evacuation. These innovative tools include elliptical spurs and knife geometry for longer life in panel processing applications.

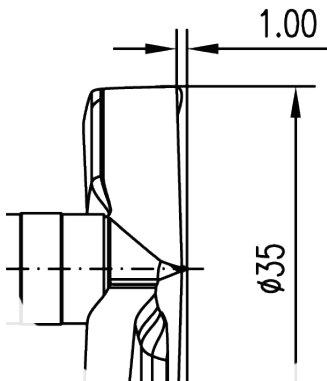
Product Specifications

Conventional Bits

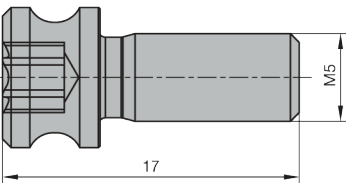
D mm	Type	GL mm	SH mm	ID# LH	ID# RH
15	Hinge	57	10 x 26	34800	34801
20	Hinge	57	10 x 26	34802	34803
26	Hinge	57	10 x 26	34806	34807
35	Hinge	57	10 x 26	34810	34811
15	Hinge	70	10 x 26	34812	34813
20	Hinge	70	10 x 26	34814	34815
26	Hinge	70	10 x 26	34818	34819
35	Hinge	70	10 x 26	34822	34823

Short Center-Point Bits

D mm	Type	GL mm	SH mm	ID# LH	ID# RH
15	Hinge	57	10 x 26	34841	38442
20	Hinge	57	10 x 26	34843	34844
25	Hinge	57	10 x 26	34845	34846
26	Hinge	57	10 x 26	34847	34848
35	Hinge	57	10 x 26	37201	37202
15	Hinge	70	10 x 26	37203	37204
20	Hinge	70	10 x 26	37205	37206
25	Hinge	70	10 x 26		37208
26	Hinge	70	10 x 26	37209	37210
30	Hinge	70	10 x 26	37211	37212
35	Hinge	70	10 x 26	37213	37214



Short center-point bit



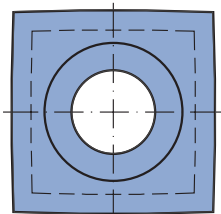
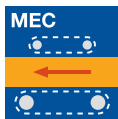
Length adjustment screw ID# 9157

Optional setting screw for quick change system ID# 9157.

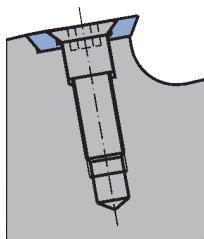


4. Planing

4.1 HeliPlan Cutterheads



HW turnblade knife



Knives mounted on periphery

HeliPlan Cutterheads with 4 Edge HW Turnblade Knives

Application:

Pre-planing, surfacing and jointing all types of wood with large chip removal. Also suitable for finish planing if quality demands are less important or in combination with subsequent sanding.

Machine:

Four-sided moulders with HSK 85 WS interfaces.

Workpiece Material:

Softwood and hardwood.

Technical Information:

Pre-planing cutterhead with 4 edge HW turnblade knives. Low-noise and energy efficient due to spiral, segmented edge arrangement. Smooth finish through radiused cutting edges. Aluminum tool body. Tool and HSK are shrink-fit together. Optional steel reference cutterhead for machines with fence.

Aluminium tool body, with HSK-85 WS

WL 210 2 02

D mm	SB mm	Wings	# of Knives	RPM max	ID# Bottom	ID# Top
125	130	2/2	22	12,000	132000	132001
125	166	2/2	28	12,000	132022	132023
125	210	2/2	36	12,000	132008	132009
125	236	2/2	40	12,000	132024	132025
125	270	2/2	46	8,000	132012	132013
125	310	2/2	54	8,000	132014	132015

Aluminium tool body, with bore

WW 220 2 01

D mm	SB mm	Boss Width mm	Bore mm	Wings	# of Knives	RPM max	ID#
125	130	136	40	2/2	22	12,000	30423
125	166	172	40	2/2	28	12,000	30467
125	210	216	40	2/2	36	12,000	30452
125	236	242	40	2/2	40	12,000	30466
140	166	172	50	2/2	28	12,000	30468
140	236	242	50	2/2	40	12,000	30469

Spare Knives

Description	Dimensions mm	QUAL	Sales Unit	ID#
Turnblade Knife	15 x 15 x 2.5	HW	10	9535
Turnblade Knife	15 x 15 x 2.5	TDC		602901

Spare Parts

Description	Dimensions mm	ID#
Countersink Screw, Torx® 20	M5 x 14.2-8.8	7394
Torx® Key	Torx® 20	6091



Planerhead VariPlan Plus

Application:

Multi-purpose planing tool:
For pre-planing with RipTec turnblades.
For finish planing with microfinish turnblades.

Machine:

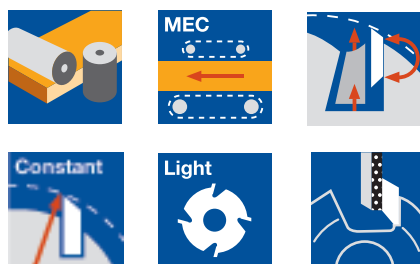
Four-sided moulders and multi-spindle moulders with HSK-85 WS interfaces.

Workpiece Material:

Softwood and hardwood, thermoplastics (partly suitable).

Technical Information:

Resharpenable and constant diameter planerhead system. Self-positioning and centrifugal force supported knife clamping. Lightweight aluminium tool body. Resharpener the knives on the cutting face means one sharpening operation gives two additional lives. Tool body and HSK arbor are shrunk fit together.


Lightweight aluminium tool body on HSK-85 WS

WP 240 2 05

D mm	SB mm	# of Knives	RPM max	Wings	Qual	ID# LH / bottom	ID# RH / top
125	130	26	12,000	2	HW-MF	134500	134501
125	150	26	12,000	2	HW-MF	134502	134503
125	166	26	12,000	2	HW-MF	134504	134505
125	180	26	12,000	2	HW-MF	134506	134507
125	210	26	12,000	2	HW-MF	134508	134509
125	236	26	12,000	2	HW-MF	134510	134511
125	270	26	8,000	2	HW-MF	134512	134513
125	310	26	8,000	2	HW-MF	134514	134515
125	130	26	12,000	4	HW-MF	134600	134601
125	150	26	12,000	4	HW-MF	134602	134603
125	166	26	12,000	4	HW-MF	134604	134605
125	180	26	12,000	4	HW-MF	134606	134607
125	210	26	12,000	4	HW-MF	134608	134609
125	236	26	12,000	4	HW-MF	134610	134611
125	270	26	8,000	4	HW-MF	134612	134613
125	310	26	8,000	4	HW-MF	134614	134615

Lightweight aluminium tool body on HSK-85 WS with reference cutterhead Z2 / V2

WP 240 2 08

D mm	SB mm	# of Knives	RPM max	Wings	Qual	Rot	ID#
125	236	26	12,000	2	HW-MF	LH / bottom	134581
125	236	26	12,000	4	HW-MF	LH / bottom	134681

Further dimensions and inch dimensions on request.

Spare knives (HS/HW-MF/HW-RipTec) see section Knives and Spare Parts.

Spare Knives

SB mm	Height mm	Thickness mm	Sales Unit	ID# HS	ID# HW-MF
130	16	3.7	2	610506	617106
150	16	3.7	2	610509	617109
166	16	3.7	2	610571	617171
180	16	3.7	2	610512	617112
210	16	3.7	2	610515	617115
236	16	3.7	2	610569	617169
270	16	3.7	2		617165
310	16	3.7	2	610522	617122

4. Planing

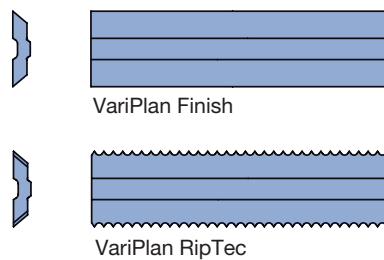
4.3 Knives



Knives

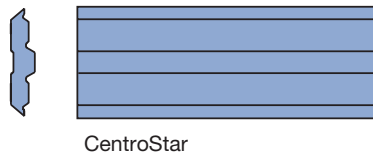
Two-sided, disposable, solid high-speed steel (HS) and solid carbide (HW) planer knives for common planing tools on moulders and thickness planers. Marathon coated (MC) knives are also available and offer a hardness approaching that of carbide, but with the durability of HS.

Product Specifications



SB mm Sales Unit	Leitz VariPlan HS Finish 2 pcs/ea	Leitz VariPlan HW Micro Finish 2 pcs/ea	Leitz Variplan HW RipTec 2 pcs/ea
100	610504	617104	611204
130	610506	617106	611206
150	610509	617109	611209
170	610511	617111	611211
210	610515	617115	611215
230	610516	617116	611216
240	610518	617118	611218

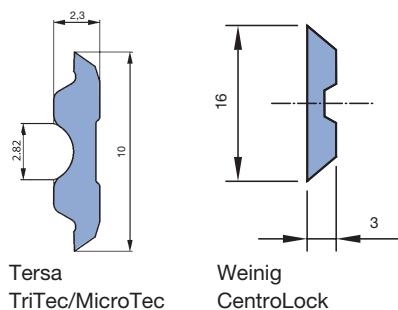
Other standard sizes available on request



Product Specifications

SB mm Sales Unit	Leitz CentroStar HS 4 pcs/ea	Leitz CentroStar MC 4 pcs/ea	Leitz CentroStar HW 2 pcs/ea
100	610203	610278	610606
130	610205	610280	610612
150	610208	610281	610616
170	610210	N/A	610620
210	610213	N/A	610627
230	610214	610283	610629
240	610215	610284	610631

Other standard sizes available on request



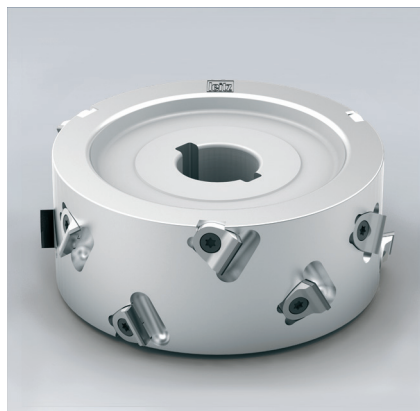
Product Specifications

SB mm Sales Unit	Tersa TriTec HS 4 pcs/ea	Tersa MicroTec HW 2 pcs/ea	Weinig CentroLock HS 2 pcs/ea	Weinig CentroLock MC 2 pcs/ea	Weinig CentroLock HW 2 pcs/ea
100	610902	610952	611803	611863	611833
130	610905	610955	611804	611864	611834
150	610907	610957	611805	611865	611835
170	610908	610958	611806	611866	611836
210	610912	610962	N/A	N/A	N/A
230	610914	610964	611809	611869	611839
240	N/A	610965	611810	611870	611840

Other standard sizes available on request

5. Edgebanding

5.1 WhisperCut 5.1.1 Pre-Mill Cutterheads



WhisperCut Pre-Mill Cutters

Application:

For pre-milling in preparation for edgebanding.

Machine:

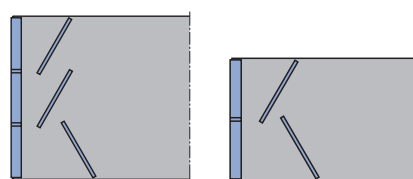
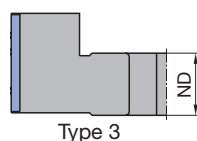
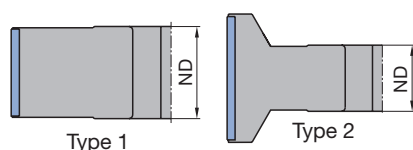
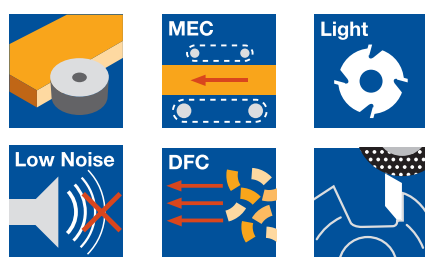
Edgebanders.

Technical Information:

Alternate shear for exceptional finish on double-sided laminates.

Product Specifications

Diamaster WhisperCut - DFC, low-noise, aluminium tool body, double keyway
WM 230-2-01



Type AS =
asymmetric tip
arrangement

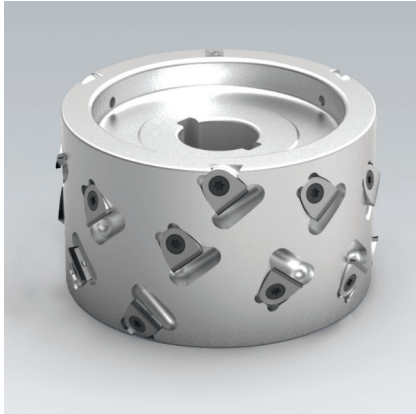
Type S =
symmetric tip
arrangement

See page 36 for WhisperCut Knives &
Spare Parts

Machine	D mm	CL mm	Bore mm	Knife Type	Type	Wings	ID# LH	ID# RH
Biesse	80	45	30	8xB	1 S	2 x 4	192127	192127
Biesse	80	65	30	12xB	2 S	2 x 6	192128	192128
Biesse	80	43	30	12xA	1 S	3 x 4	192088	192088
Biesse	100	65	30	18xA	1 S	3 x 6	192089	192089
Brandt	100	43.6	30	12xA	3 AS	3 x 4	90885	90886
Brandt	100	65.2	30	18xA	3 AS	3 x 6	90887	90888
Brandt	100	85	30	24xA	3 AS	3 x 8	90889	90890
Brandt	100	105	30	30xA	3 AS	3 x 10	90891	90892
Brandt	100	43.6	25	8xA	3 AS	2 x 4	192211	192212
Cehisa	100	54	20	10xA	2 AS	2 x 5	192078	192079
Felder	60	63	25	12xC 2xC2	3 AS°	2 x 7	192277	
Felder	60	63	25	12xC 2xC1	3 AS°	2 x 7		192278
Felder	80	48.5	25	12xB 3xB1 3xB2	3 AS°	3 x 6	192281	192282
Felder	80	64	25	18xB 3xB2	3 AS°	3 x 7	192279	
Felder	80	64	25	18xB 3xB1	3 AS°	3 x 7		192280
Holz-Her	100	63	30	18xB	2 S	3 x 6	192147	192148
Holz-Her	70	48	30	8xD 2xD1	4 AS°	2 x 5	192222	
Holz-Her	70	48	30	8xD 2xD2	4 AS°	2 x 5		192221
Holz-Her	70	64	30	12xD 2xD1	4 AS°	2 x 7	192224	
Holz-Her	70	64	30	12xD 2xD2	4 AS°	2 x 7		192223
Homag/Biesse	125	43	30	12xE	2 S	3 x 4	75627	75627
Homag/Biesse	125	63	30	18xE	2 S	3 x 6	75626	75626
IMA	125	32	30	12xD	1 AS	3 x 4	192092	192093
IMA	125	43	30	15xD	2 AS	3 x 5	192094	192095
IMA	125	63	30	21xD	3 AS	3 x 7	192096	192097
IMA Advantage	125	43	30	15xD	4 AS	3 x 5	192098	192099
IMA Advantage	125	65	30	21xD	4 AS	3 x 7	192100	192101
Holz-Her	100	43	30	8xA	2 AS	2 x 4	192082	192083
Holz-Her	100	65	30	12xA	2 AS	2 x 6	192084	192085
SCM/Stefani	100	51	30	8xB 2xB1 2xB2	3 AS°	2 x 6	192215	192216
SCM/Stefani	100	66	30	12xB 2xB1	3 AS°	2 x 7	192213	
SCM/Stefani	100	66	30	12xB 2xB2	3 AS°	2 x 7		192214
SCM/Stefani	100	51	30	12xB 3xB1 3xB2	3 AS°	3 x 6	192217	192218
SCM/Stefani	100	66	30	18xB 3xB1	3 AS°	3 x 7	192219	
SCM/Stefani	100	66	30	18xB 3xB2	3 AS°	3 x 7		192220

5. Edgebanding

5.1 WhisperCut 5.1.2 EdgeExpert



WhisperCut EdgeExpert

Application:

For tear-free and noise-reduced jointing of workpiece cutting surfaces with and against feed (jump cutting) particularly for sensitive decorative papers, foil coatings and veneers.

Machine:

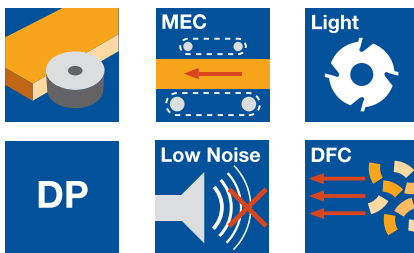
Edgebanders, copy shaping machines, double-end tenoners, etc.

Workpiece Material:

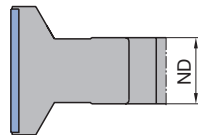
Chip and fiber boards (MDF, etc.) raw, veneered, plastic and paper coated, reinforced plastics (GFRP, CFRP, etc.)

Technical Information:

DP tipped cutterhead with alternate shear angle for tear-free jointing edges and cutting surface. Increased shear angle for excellent edge quality on sensitive decorative papers, foil coatings and veneers. Tool with knife arrangement S can be used left and right and produces hollow cut for tightly fitting edgebanding. Low noise design with up to 5 dB(A) noise reduction and highly efficient chip collection (<95°) by DFC. Significant weight reduction by using an aluminium alloy tool body. Carrier body for multiple use with exchangeable knives. 0.6 mm resharpening area.



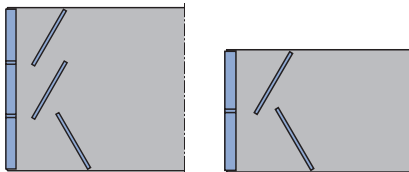
Diamaster WhisperCut EdgeExpert - DFC, low-noise, aluminium alloy tool body
WM 320 2 01



Position of Type 2



Position of boss (Type) 3



Type AS =
asymmetric tip
arrangement

Type S =
symmetric tip
arrangement

Machine	D mm	CL mm	ND mm	Bore mm	Drive	$n_{\max}$ $n_{\min}^{-1}$	Z	Type	ID# LH	ID# RH
Biesse	125	43	40	30	DKN 2	13700	3 x 6	S	192249	192249
Biesse	125	63	40	30	DKN 2	13700	3 x 8	S	192250	192250
Homag	125	43	40	30	DKN 2	13700	3 x 6	S	192249	192249
IMA	125	43	40	30	DKN 3	13700	3 x 6	AS	192251	192252
IMA	125	63	40	30	DKN 3	13700	3 x 8	AS	192253	192254

Replacement knives ground to order

WhisperCut Pre-Mill Cutters

Knives & Spare Parts

Description	Dimensions mm	Type	Shape	ID#
WhisperCut	14 x 14.2 x 4.3	A	1	91052
WhisperCut	14 x 14.2 x 4.3	B	1	91066
WhisperCut	6.7 x 14.2 x 4.3	B1	2	91067
WhisperCut	6.7 x 14.2 x 4.3	B2	3	91068
WhisperCut	14 x 14.2 x 4.3	D	1	91071
WhisperCut	6.7 x 14.2 x 4.3	D2	2	91072
WhisperCut	6.7 x 14.2 x 4.3	D1	3	91073
WhisperCut	14 x 14.2 x 4.3	E	1	91074
WhisperCut	14 x 14.2 x 4.3	C	1	91077
WhisperCut	6.7 x 14.2 x 4.3	C1	2	91079
WhisperCut	6.7 x 14.2 x 4.3	C2	3	91078
Clamping Screw	M5 x 12.9	T25		7899
Wrench for Above	T-Handle	T25		5502
Securing Part Set	40/30 x 8 x M12	Holz-Her		116011
Spindle Nut	38 x 28 M25 x 1.5	Felder		66566

5. Edgebanding

5.2 Snip Saw Blades



Circular Sawblade for end trim on edgebanders

Application:

For low noise edgebanding trim cuts.

Machine:

Single or double-sided edgebanding machines and double-end tenoners.

Workpiece Material:

Softwood, hardwood, veneered, melamine and plastic edging.

Technical Information:

Tooth geometries and pitch designed for optimum cutting quality.

Veneered and plastic edging:

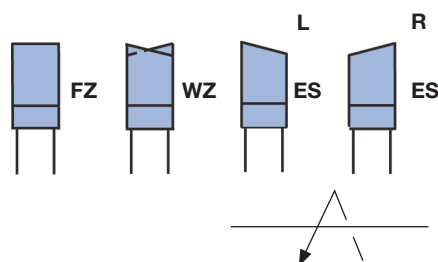
Edging thickness > 2.0 mm - crosscut saw ES pos.

Edging thickness < 2.0 mm - crosscut saw ES neg.

Solid wood edging and multi-purpose application:

Edging thickness > 2.0 mm - crosscut saw WZ pos.

Edging thickness < 2.0 mm - crosscut saw WZ neg.

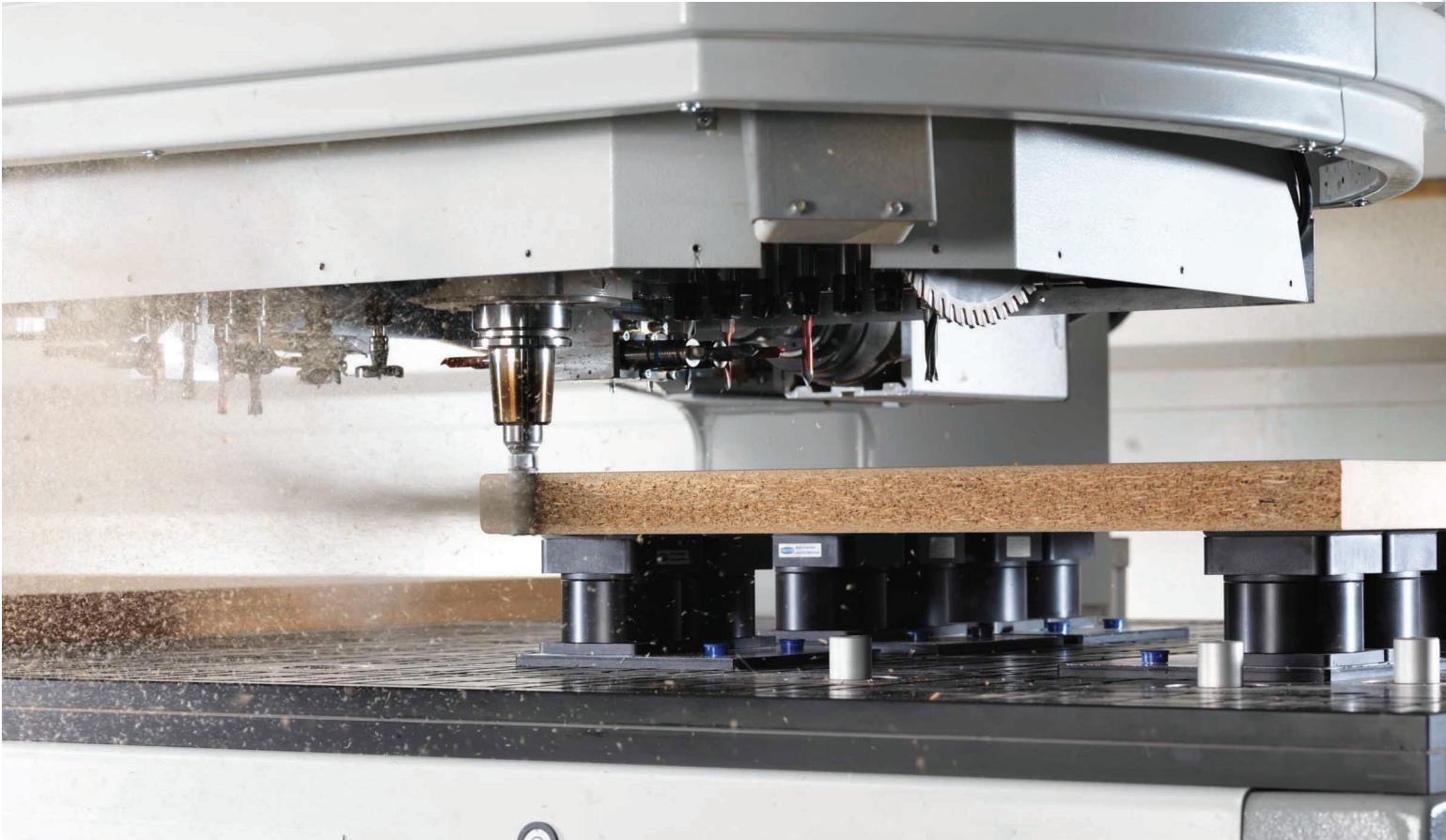


Circular Saw Blade - low-noise

SK 499 2, WK 101 2, WK 250 2, WK 300 2, WK 301 2, WK 311 2, WK 321 2, WK 331 2, WK 350 2, WK 360 2, WK 370 2, WK 372 2, WK 380 2, WK 850 2

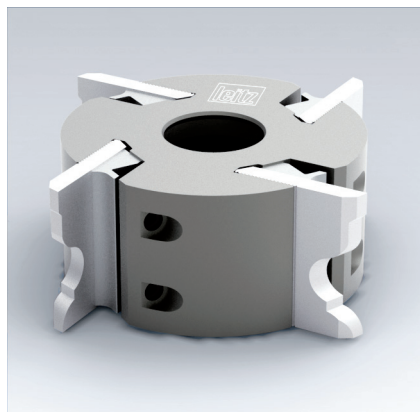
Machine	D mm	Kerf mm	Bore mm	Teeth	Hook	$n_{\max}$ min^{-1}	ID# LH	ID# RH
Biesse	115	3.2	52	30	ES pos.	19900	166421	166420
Biesse	115	3.2	56	30	ES pos.	19900	166423	166422
Biesse	130	3.6	30	24	ES pos.	17600	166425	166424
Biesse	140	3.2	30	36	ES pos.	16300	166426	166427
Biesse	160	3.2	20	48	WZ pos.	14300	166428	166428
Brandt	100	2.6	32	30	ES neg.	22900	166400	166401
Brandt	100	2.6	32	30	ES pos.	22900	166429	166430
Brandt	100	2.6	32	30	WZ pos.	22900	166431	166431
Brandt	110	2.4	32	40	ES pos.	20800	166432	166433
Brandt	125	2.4	32	24	WZ pos.	18300	166402	166402
Brandt	125	2.6	32	30	ES neg.	18300	166403	166404
Brandt	150	2.8	20	36	ES pos.	15200	166434	166435
Cehisa	100	3.0	32	30	ES pos.	22900	166436	166437
Felder	100	3.2	22	20	WZ pos.	22900	166438	166438
Holz-Her	110	3.6	22	16	ES	20800	166439	166440
Holz-Her	140	3.2	22	36	WZ pos.	16300	166441	166441
Holz-Her	160	3.2	20	48	WZ pos.	14300	166428	166428
Holz-Her	160	2.8	30	24	WZ pos.	14300	166442	166442
Homag	80	3.2	34	30	ES pos.	28600	166444	166443
Homag	100	3.0	32	20	ES pos.	22900	166445	166446
Homag	100	3.0	32	20	ES pos.	22900	166448	166447
Homag	100	3.2	32	20	ES neg.	22900	166449	166450
Homag	100	3.6	32	20	WZ pos.	22900	166451	166451
Homag	100	2.6	32	30	ES pos.	22900	166429	166430
Homag	100	2.6	32	30	WZ pos.	22900	166431	166431
Homag	110	3.6	32	20	WZ pos.	20800	166452	166452
Homag	110	2.4	32	40	ES pos.	20800	166432	166433
Homag	110	1.7	40	30	FZ/TR pos.	20800	166453	166453
Homag	120	3.6	40	24	WZ pos.	19000	166419	166419
Homag	120	3.2	40	30	ES pos.	19000	166454	166455
Homag	120	3.2	40	36	WZ pos.	19000	166456	166456
Homag	120	3.6	40	36	WZ pos.	19000	166457	166457
Homag	150	2.8	20	36	ES pos.	15200	166434	166435
Homag	150	3.5	30	40	ES pos.	15200	166459	166458
Homag	170	3.2	30	36	WZ pos.	13400	166412	166412
Homag	180	3.2	30	54	WZ pos.	12700	166460	166460

Machine	D mm	Kerf mm	Bore mm	Teeth	Hook	$n_{\max}$ min^{-1}	ID# LH	ID# RH
IMA	160	3.5	22	36	WZ neg.	14300	166462	166462
IMA	160	3.2	22	48	WZ neg.	14300	166414	166414
IMA	180	3.2	22	48	WZ pos.	12700	166463	166463
IMA	180	3.2	22	48	WZ neg.	12700	166464	166464
IMA	200	3.2	30	64	WZ neg.	11400	166465	166465
IMA 08.415	180	3.5	22	42	WZ neg.	12700	166415	166415
IMA 08.492	140	3.0	22	36	WZ pos.	12700	166413	166413
Raimann	100	3.6	32	20	WZ pos.	22900	166451	166451
Raimann	120	3.2	32	20	WZ neg.	19000	166467	166467
SCM	115	3.2	30	30	WZ pos.	19900	166416	166416
SCM	150	3.8	35	24+6	ES pos.	15200	166469	166468



6. Profiling

6.1 Corrugated Cutterheads, Knives



Corrugated Cutterheads & Blank Knives

Application:

Custom profiling.

Machine:

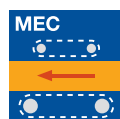
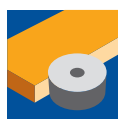
Moulders.

Workpiece Material:

Softwood and MDF.

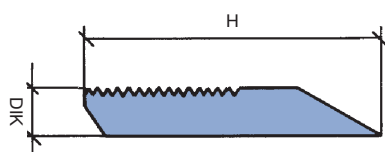
Technical Information:

Dual angle heads are adaptable for any wood species (use 20° knife pockets for softwoods or MDF and 12° knife pockets for hard woods). Ensure that knives are maintained and utilized in two-piece balanced sets.



Product Specifications

D mm	SB mm	Bore	Wings	Hook	ID#
137	60	1-13/16"	2+2	12°/20°	100220559
137	100	1-13/16"	2+2	12°/20°	100220564
137	150	1-13/16"	2+2	12°/20°	100220566
137	230	1-13/16"	2+2	12°/20°	100220568



Height	Thickness	Length	Grade	ID#
1-1/2"	5/16"	25"	D2/SRS	130038846
1-3/4"	5/16"	25"	D2/SRS	130038847
2"	5/16"	25"	D2/SRS	130038848
2-3/8"	5/16"	25"	D2/SRS	130038849
2-3/4"	5/16"	25"	D2/SRS	130038850

Height	Max Profile Depth
1-1/2"	0 mm
1-3/4"	10 mm
2"	15 mm
2-3/8"	20 mm
2-3/4"	30 mm

Height	Thickness	Length	Grade	ID#
1-1/2"	5/16"	25"	M2	130001715
1-3/4"	5/16"	25"	M2	130001716
2"	5/16"	25"	M2	7306
2-3/8"	5/16"	25"	M2	7307
2-3/4"	5/16"	25"	M2	7308

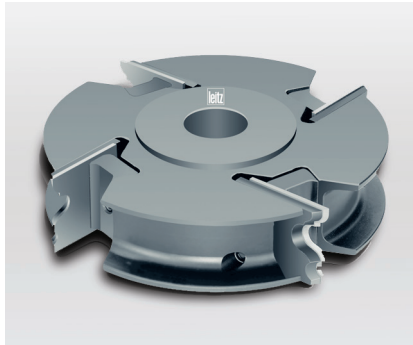
D2	Ideal for short runs or knotty materials
M2	Acceptable service life for medium run profiles
T1	Enhanced with 18% tungsten for greatly extended service life
M3+	Contains hard alloys for optimized service life in abrasive materials

Height	Thickness	Length	Grade	ID#
1-1/2"	5/16"	25"	T1/ Eco B18	190202100
1-3/4"	5/16"	25"	T1/ Eco B18	190202101
2"	5/16"	25"	T1/ Eco B18	190202102
2-3/8"	5/16"	25"	T1/ Eco B18	190111185
2-3/4"	5/16"	25"	T1/ Eco B18	190202103

Height	Thickness	Length	Grade	ID#
1-1/2"	5/16"	25"	M3+	130038841
1-3/4"	5/16"	25"	M3+	130038842
2"	5/16"	25"	M3+	130038843
2-3/8"	5/16"	25"	M3+	130038844
2-3/4"	5/16"	25"	M3+	130038845

6. Profiling

6.2 VariForm Cutterheads



Application:

For cutting profiles. Different profiles with a maximum of 20 mm profile depth can be mounted.

Machine:

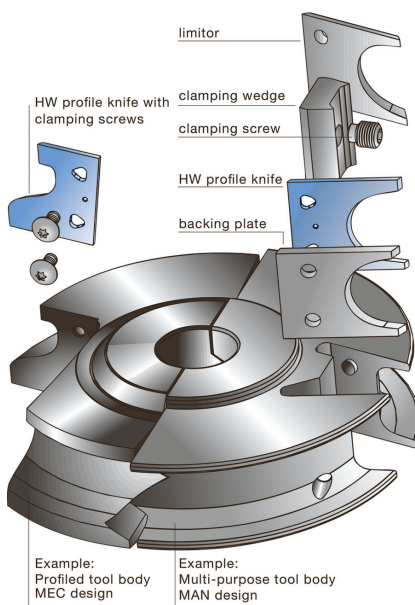
Moulders, double end tenoners, edgebanding machines, etc.

Workpiece Material:

Softwood and hardwood (HW-30F), panel materials or glued wood (HW-10F).

Technical Information:

Multi-purpose cutterhead with tungsten carbide special profile knives and backing plates. Can be resharpened three to four times.



Product Specifications

D mm	SB mm	Bore	Bore max mm	PT max mm	Wings Type	ID#
135	30	1-1/4"	1-14"	20	2 Dedicated	135215
200	30	1-1/4"	50	20	3 Dedicated	135216
150	40	1-1/4"	1-1/4"	20	2 Universal	135217
200	40	1-1/4"	50	20	3 Universal	135218
102	40	SH=3/4"	N/A	20	2 Dedicated	130045295

Spare Parts

Description	Dimensions	ID#
Torx® Screw	M5 x 10 x 13.5, T25	7383
Allen Key	T25 x 100	5502

Universal tool body, mechanical feed, Z2 - Z4 U profile

D mm	SB mm	Bore mm	Bore max mm	PT max mm	Wings	RPM max	ID#
165	40	30	40	20	2	10,000	135212
165	50	30	40	20	2	10,000	135213
165	60	30	40	20	2	10,000	134214
180	40	35 DKN	35	20	4	9,000	135203
180	50	35 DKN	35	20	4	9,000	135204
180	40	30	50	20	4	9,000	135206
180	60	30	50	20	4	9,000	135208

Supplied with clamping wedges, but without backing plates and knives

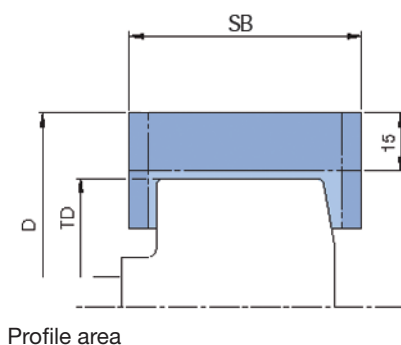
Universal CNC tool body, mechanical feed, Z2

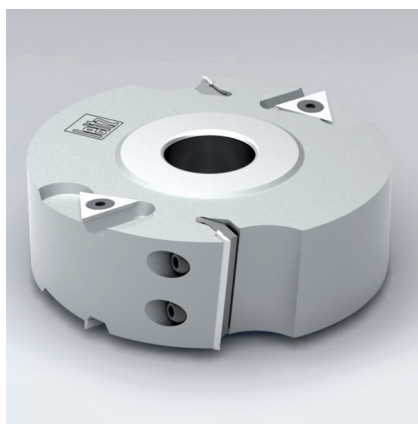
D mm	SB mm	Shank mm	PT max mm	Rot	RPMs max	ID#
110	40/45	25 x 60	15	RH	12,000	135400
110	50/60	25 x 60	15	RH	12,000	135401

Supplied with clamping wedges, but without backing plates and knives

Spare Parts

Description	Dimensions	for SB mm	ID#
Clamping Wedge	36 x 13, 21 x 26	40/45	9756
Clamping Wedge	56 x 13, 21 x 26	60	9757
Clamping Wedge	44 x 13, 21 x 24, 25	50/60	9760
Allen Screw with ISK 5	M10 x 12		6044
Allen Key	SW 5, L100		117506





Rebating Cutterhead

Application:

For jointing, rebating and grooving.

Machine:

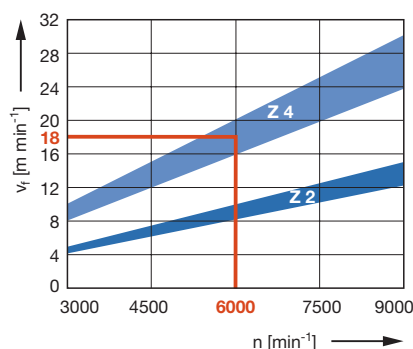
Spindle moulders (running against feed), double-end tenoners, edgebanders, etc. (running with feed or against feed e.g. jump cutting). Stationary routers with/without CNC control.

Workpiece Material:

Softwood and hardwood, glulam, plastics, etc.

Technical Information:

Cutterhead with alternate shear angle and triangular spurs.



Product Specifications

Turnblade rebating cutterhead

WW 420 1 02

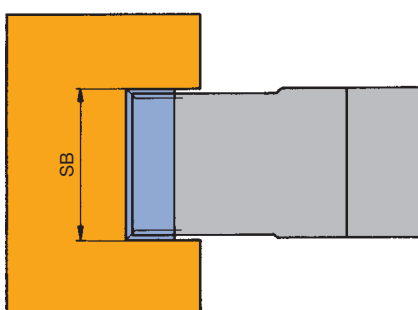
D mm	CL mm	Bore mm	Bore max mm	Teeth	Spurs	n (max)	ID#
85	51	30	40	2	4	20200	24555
100	51	30	40	2	4	17100	24568
125	41	30	40	2	4	13700	24546
125	51	30	50	2	4	13800	24569
125	51	40	50	2	4	13800	24570
125	51	50	50	2	4	13800	24571
150	51	30	40	2	4	11400	24548
150	61	30	50	4	4	11400	24543

Spare Knives

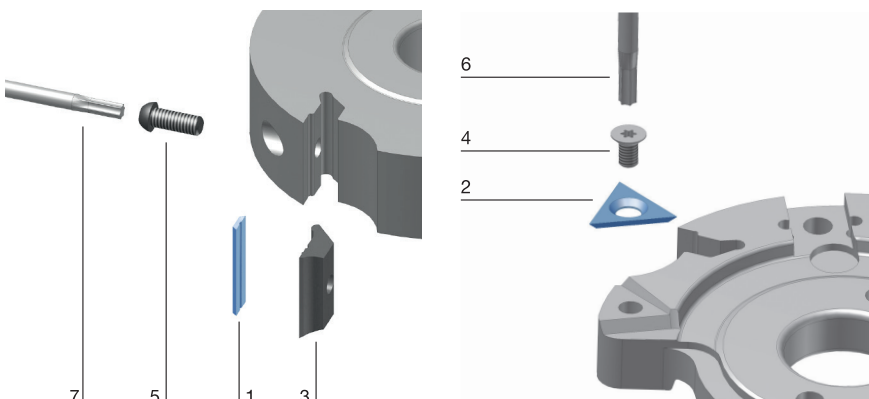
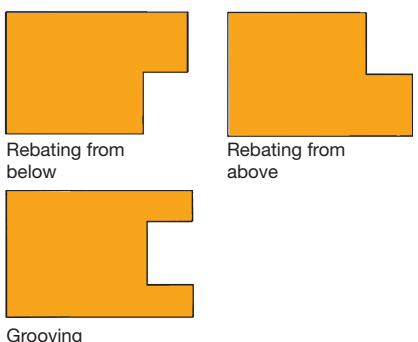
Description	Part#	Dimensions mm	Qual	Sales Unit	ID#
Turnblade Knife	1	40 x 8 x 1.5	HW-30F	10	5074
Turnblade Knife	1	50 x 8 x 1.5	HW-30F	10	5075
Turnblade Knife	1	60 x 8 x 1.5	HW-30F	10	5076
Turnblade Knife VS2	2	19 x 19 x 2	HW-F	10	5115

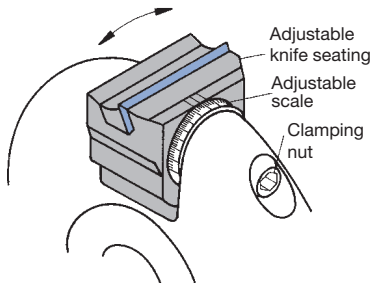
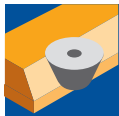
Spare Parts

Description	Part#	Dimensions mm	ID#
Clamping Wedge	3	38 x 18.75 x 8.27	9675
Clamping Wedge	3	48 x 18.75 x 8.27	9677
Clamping Wedge	3	58 x 18.75 x 8.27	9678
Countersink Screw Torx® 20	4	M5 x 8.5	7808
Clamping Screw w. Disc, Torx® 25	5	M6 x 18.5	7442
Torx® Key	6	Torx® 20	117503
Torx® Key	7	Torx® 25	117504
Setting Gauge for Knives		0.3, 0.8	5374



Tool set





Bevel cutterhead with swiveling knife holder

VariAngle Bevel Cutterhead

Application:
For jointing, beveling and raised panels with stepless adjustable bevel angles +/- 60°.

Machine:
Stationary routers with/without CNC control, machining centers.

Technical Information:
Quick adjustment to typical angles 15°, 30°, 45°, and 60° with positive stop. Other intermediate angles via bezel scale.

Insert design: 2-edged conventional carbide inserts suitable for a wide range of materials. Maximum material thickness 34 mm @ 45°.

HeliCut design: 4-edge carbide inserts with aggressive alternative shear geometry, particularly suitable for solid wood and soft materials. Maximum material thickness 38 mm @ 45°.

WhisperCut design: 1-edge diamond inserts with alternative shear for chip-free edges, top and bottom, particularly well-suited for abrasive materials.

Adjustable bevel cutterhead
WW 341 1

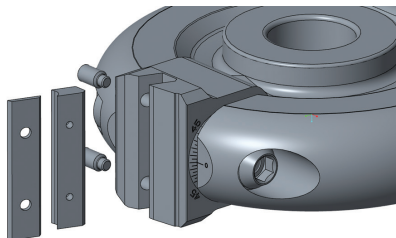
Description	D mm	SB mm	Bore mm	Wings	Knife Material	ID#
Turnblade cutterhead, swiveling	150	50	30	1+1	HW	24169
Turnblade cutterhead, swiveling	150	50	31.75	1+1	HW	24170
Turnblade cutterhead, swiveling	150	50	40	1+1	HW	24171
Helicut cutterhead, swiveling	150	57	30	1+1	HW	24290
Helicut cutterhead, swiveling	150	57	31.75	1+1	HW	24262
Helicut cutterhead, swiveling	150	57	40	1+1	HW	24264
WhisperCut cutterhead, swiveling	150	57	30	1+1	DP	24291
WhisperCut cutterhead, swiveling	150	57	31.75	1+1	DP	24263
WhisperCut cutterhead, swiveling	150	57	40	1+1	DP	24265

Spare Knives: Insert Design

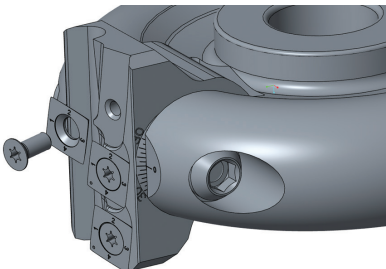
Description	Part#	Dimensions mm	Qual	Sales Unit	ID#
Turnblade Knife	1	50 x 12 x 1.5	HW-05F	10	5086

Spare Parts: Insert Design

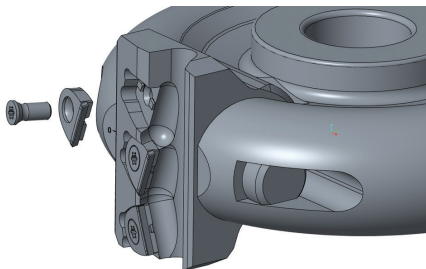
Description	Part#	Dimensions mm	ID#
Clamping Wedge with Pin	2	38 x 10.88 x 6	5348
Allen Screw	3	M6 x 12	6035
Allen Key		SW 8, L 100	5437
Allen Key		SW 3	5433
Setting Gauge for Knives		80 x 12 x 9.5	5352



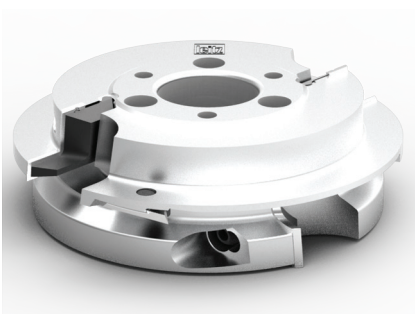
Insert Design



HeliCut Design



WhisperCut Design

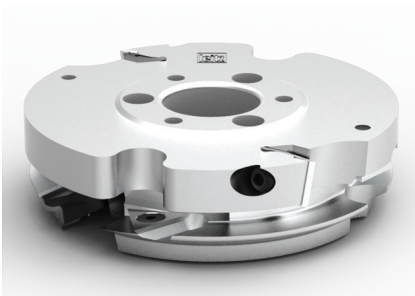


American Standard ProfilCut Cope & Stick Cutter Set

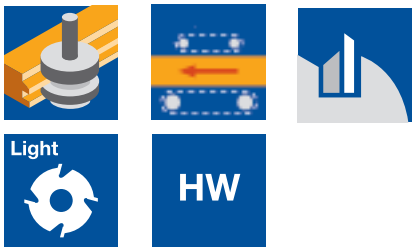
Application:
For cope and stick profiles in solid wood cabinet doors. Multiple profiles possible with simple knife changes.

Machine:
Shapers and CNC routers.

Workpiece Material:
Softwood and hardwood.



Technical Information:
Lightweight design allows for use on 1-1/4" as well as 1" and 3/4" shapers (with bushings) and CNC routers. For 3/4" to 7/8" thick cabinet frames. Three standard profiles plus capabilities for custom profiles.



Product Specifications

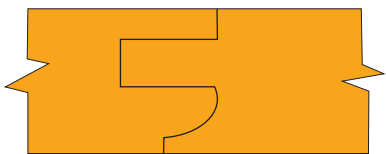
Cutter Set With Profile 1 Inserts

Tool Type	Tool #	Wings	n (max)	Bore	ID#
Stick Cutter Set	1, 2	2+2	13,700	1-1/4"	168312345
Cope Cutter Set	3, 4	2+2	13,700	1-1/4"	168312346

Profile Inserts

Profile #	Tool #	Description	Qual	ID#
1	1	Stick Profile Knife 1	HW	168312347
1, 2, 3	2	Stick Grooving Knife	HW	168312348
1	3	Cope Profile Knife 1	HW	168312349
2	1	Stick Profile Knife 2	HW	168312350
2	3	Cope Profile Knife 2	HW	168312351
3	1	Stick Profile Knife 3	HW	168312352
3	3	Cope Profile Knife 3	HW	168312353
All	4	8 x 15 mm Turnblade	HW	5056
All	2, 3, 4, 6	Spur Knives	HW	5115

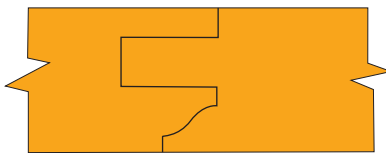
Profile 1 - Bead



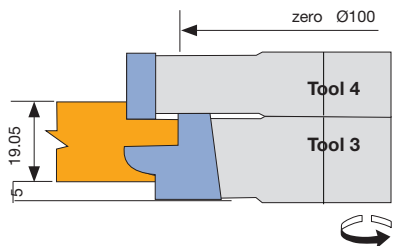
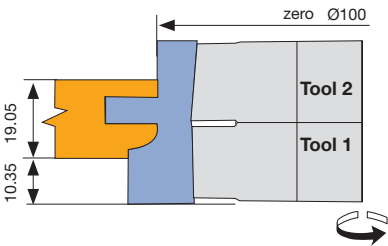
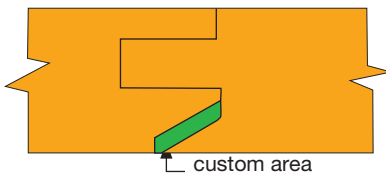
Profile 2 - Ovalo



Profile 3 - Ogee

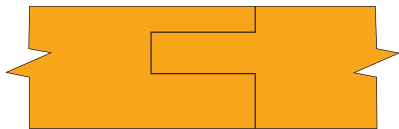


Custom Profile



American Standard ProfilCut Cope & Stick Cutterset

Profile 4



Profile 5 - Glass Door

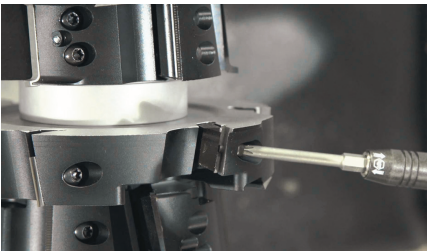
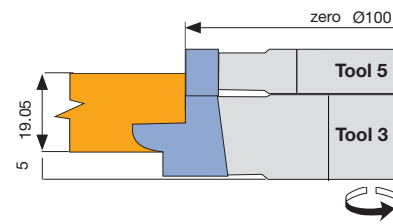
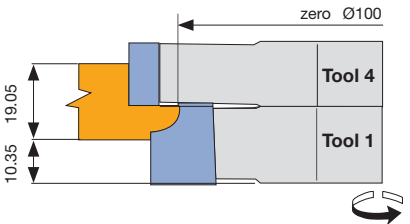
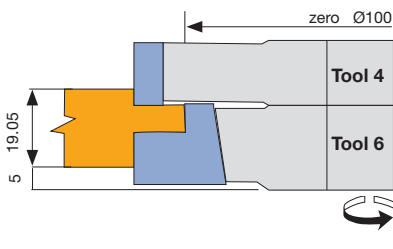
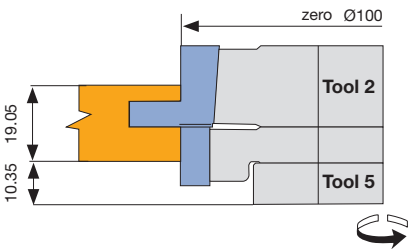


Accessories for Product Expansion - Profile 4 With Profile Inserts

Tool Type	Tool #	Wings	n (max)	ID#
Jointing Cutter (part of stick)	5	2	13,700	168312588
Profile Cutter (part of cope)	6	2	13,700	168312355

Profile Inserts

Profile #	Tool #	Description	Qual	ID#
4	2	Mission Stick Profile Knife	HW	168312348
4	6	Cope Profile Knife	HW	168312356
4	5, 4	8 x 15 mm Turnblade	HW	5056
All	2, 3, 4, 6	Spur Knives	HW	5115

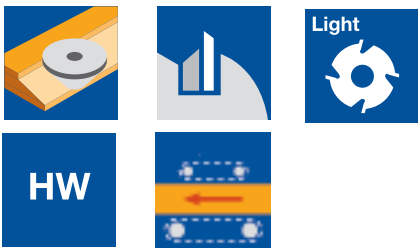


ProfilCut Q and Q Premium

Ideal for windows, doors, furniture and flooring, **ProfilCut Q** cutterheads include easily changeable knives and a new, patent-pending, clamping system which positions the knives radially and axially within an extremely tight tolerance.

ProfilCut Q Premium is the right choice for a top-performing insert tooling system used in high production settings. The innovative tool design provides exceptional results in every area: cutting speed, flexibility, ease of use, weight, and longevity. Q Premium out-performs any insert system on the market in productivity and surface quality, saving time and money!

The Leitz ProfilCut Q product line meets demanding expectations for durability and accuracy, while providing exceptional quality and speed. Call us at (800) 253-6070 to find out more.



Profile 1



Profile 2



Profile 3



Profile 4



Profile 5



Custom Profile



ProfilCut Profile Cutterheads

Application:

For raised panel profiles; multiple profiles possible with simple knife change.

Machine:

Shapers and CNC routers.

Workpiece Material:

Softwood and hardwood.

Technical Information:

Cutterheads with disposable inserts, shear angle.

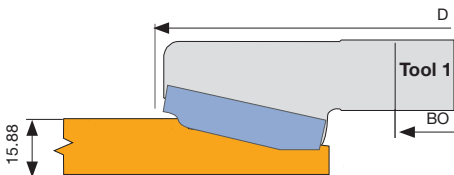
Cutterhead with Profile 1 inserts

WE 550 1 50

Tool #	D mm	Bore	Wings	n (max)	ID#
1	155	1-1/4"	2	11,000	168312357

Profile Inserts

Tool #	Description	Dimension	Profile	ID#
1	ProfilCut Knife	40 x 14.5 x 2	1	168312358
1	ProfilCut Knife	40 x 14.5 x 2	2	168312359
1	ProfilCut Knife	40 x 14.5 x 2	3	168312360

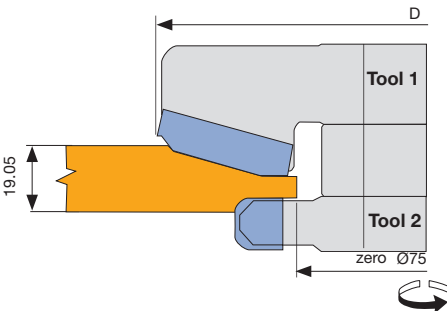


Back Panel Cutterhead with Profile 4 Inserts

Tool #	D mm	Bore	Wings	ID#
2	110	1-1/4"	2	168312589

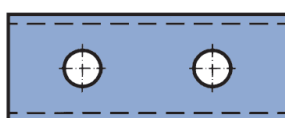
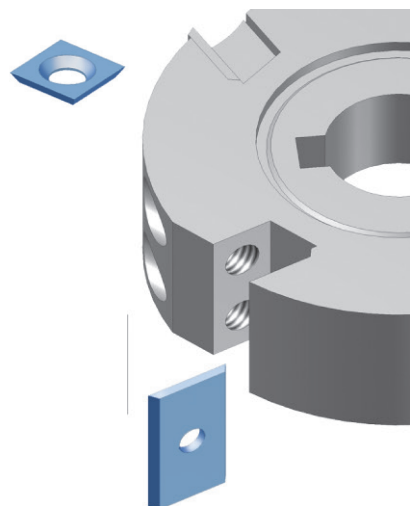
Profile Inserts

Tool #	Description	Dimension	Profile	ID#
2	ProfilCut Knife R5	15 x 13 x 2	4	168312362
2	ProfilCut Knife 45°	15 x 13 x 2	5	168312363

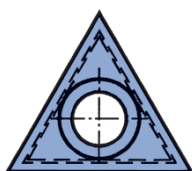


7. Standard Knives

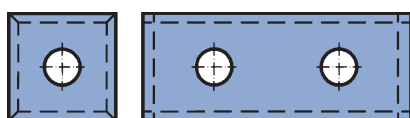
7.1 Standard Knives



B2



B3



B4

Standard Replacement Turnblade and Spur Knives

Workpiece Material:

Solid wood and panel products.

Length mm	Height mm	Thickness mm	Diagram	Qual	Sales Unit	ID#
12	12	1.5	B2	HW-05	10	5081
15	12	1.5	B2	HW-05	10	5082
20	12	1.5	B2	HW-05	10	5083
30	12	1.5	B2	HW-05	10	5084
30	12	1.5	B2	HW-05	10	5061
40	12	1.5	B2	HW-05	10	5085
50	12	1.5	B2	HW-05	10	5086
50	12	1.5	B4	HW-05	10	6506
60	12	1.5	B2	HW-05	10	5087
14	14	2	B4		10	5099
15	15	2.5	B4		10	9535*
15	15	2.5	B4		10	9549**
15	15	2.5	B4		10	9543***
14.3	14.3	2.5	B4		10	5426
19	19	2	B3		10	5115

* HeliPlan

** HeliCut

*** HeliCut MF

Workpiece Material:

Abrasive wood-derived materials and plastics.

Length mm	Height mm	Thickness mm	Diagram	Qual	Sales Unit	ID#
20	12	1.5	B4	HW-03F	10	6904
30	12	1.5	B2	HW-03F	10	6905
50	12	1.5	B2	HW-03F	10	6906

Workpiece Material HW-05 MC:

Extremely abrasive wood-derived materials and plastics.

Length mm	Height mm	Thickness mm	Sales Unit	ID# K30F	ID# K05	ID# K05MC
7.7	8	1.5	10	5068	5053	601628
9.7	8	1.5	10	5197	5054	601629
11.7	8	1.5	10	5069	5055	601630
14.7	8	1.5	10	5070	5056	601631
19.7	8	1.5	10	5071	5057	601632
25	8	1.5	10	5198	5058	601633
30	8	1.5	10	5072	5059	601634
35	8	1.5	10	5073	5400	601635
40	8	1.5	10	5074	5401	601636
45	8	1.5	N/A	7679	7681	601637
50	8	1.5	10	5075	5402	601638
60	8	1.5	10	5076	5403	601639
70	8	1.5	N/A	7680	7682	601640
80	8	1.5	N/A	5077	5404	601641
100	8	1.5	N/A	5184	5405	601642
120	8	1.5	N/A	5185	5406	601643



Leitz Tooling Services

Our unparalleled knowledge in tooling support is merged with state-of-the-art sharpening and conditioning services to ensure that your business can rely on quality, convenient solutions.

Technical Support

Continuous, advanced training keeps our staff on the cutting edge of product knowledge. Our worldwide network of experts problem-solve even the most challenging applications. From customized tooling solutions to tool logistics, count on Leitz for outstanding technical support.

Service Centers

Located throughout North America, Leitz service centers provide precision sharpening and reconditioning services to restore tools to "like new" condition. Our tooling solutions ensure longer production runs, reduced downtime, maximized tool life, and optimized performance—while decreasing production costs.

Your Leitz service center schedules pick-up and delivery, tailored to meet your needs. Our partnership with national shipping companies results in quick turn-around as well as easy, cost-effective and safe transport of your valuable tools.

With our commitment to complete customer care, Leitz tooling services provide comprehensive value as your local tooling source. Contact us today.

contact@leitz.org
800.253.6070

Your Partner in Innovation



Leitz Service Center Locations

USA

Michigan (Corp. Headquarters)
4301 East Paris Avenue SE
Grand Rapids, MI 49512
Tel. 800 253 6070

California
1145 East Orange Show Road
Units E & F
San Bernardino, CA 92408
Tel. 800 548 1535

North Carolina
401 Interstate Drive
Archdale, NC 27263
Tel. 800 860 8848

Texas
2721 Market Street
Garland, TX 75041
Tel. 214 703 9314

Washington
8607 South 212th Street
Kent, WA 98031
Tel. 253 395 1012



Leitz Tooling Systems LP

USA Headquarters
4301 East Paris Avenue SE
Grand Rapids, MI 49512
Tel. 800 253 6070
Fax 800 752 9391
E-Mail insidesales@leitz.org
www.leitztooling.com